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Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14285	36/50
2	Machined By		V.T.L. H/C Shop	Drg. No. L2-C-998
3	Pallet Die No.		14185(3.0) H/C	Rev. 00
4	Die Category	Drg. No.	Ext. outside	
5	Out Side Diameter	Drg. No.	62mm Step OD. Tappers 12°	
6	Inside Diameter	Drg. No.	52.12 H/C	Step length 18.5mm
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H/C of H.Pes. 12° Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/8/25

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter = 6° Rov = 38
2	External Relief Dia	3.5mm	80 side (3-3)		Inner			
3	External Relief Depth		20mm		14mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		18	2	25			

Inspected By (Sign) & Date

Ravi 18/8/25

Satyam 18/8/25

Reviewed by (Engineer-CNC)

Manager-QA