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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.		14236 ✓	35/40
2	Machined By		V. T. L. H/c Shop	Drg No. 1-3-02-835
3	Pallet Die No.		13972 (5.0) H/c	Rev. No.
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c	
6	Inside Diameter	Drg. No.	Step 00: 491 H/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	420.2 H/c	
8	Grooves as per Drawing	Drg. No.	158 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 H/c 12 x 8 x 3 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	Tapping No. of holes = 8 Bottom Side
13	Tapping Hole Diameter		0.314" = Check by 0.314" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.3 H/c	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/07/25

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 60° Rev. 17
2	External Relief Dia	5.5 H/c	outside 2.25		inner			
3	External Relief Depth		10 H/c		5 H/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Ramesh
6	Material Sent For Hardening On Date		25	25	25			

Inspected By (Sign) & Date

Ravi 25/07/25

Reviewed by (Engineer-CNC)

Manager-QA