

9289



Lark Engineering Company (India) Pvt. Ltd.

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

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| 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. | | 14221 | 40/50 |
| 2 | Machined By | | V.T.L. H/C Shop | Dry Hole 12.02 493 |
| 3 | Pallet Die No. | | 13558(4.0) H | Rev 2.00 |
| 4 | Die Category | Drg. No. | M. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 700 H Step 00.693 H | Tapper 12 |
| 6 | Inside Diameter | Drg. No. | 600.12 H | Step length 20 H |
| 7 | Width of Pellet Die | Drg. No. | 222 H | |
| 8 | Grooves as per Drawing | Drg. No. | 12x10x7.5 H | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 12x10x7.5 H | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | H/C Shop | |
| 12 | Tapping PCD | | 640 H | Tapping No of Holes 12 Both Side |
| 13 | Tapping Hole Diameter | | H20 Check by H20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth 20.3 H Tapping Depth 18.9 H | |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 25/8/25

| | | | |
|---|--------------------------------|--------|----|
| 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

Counter 60

| | | | | | | | | |
|---|--|-------|--------------|---|--------------|--|--|--|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | |
| 2 | External Relief Dia | 4.5 H | Outside 3-3) | | Inner | | | |
| 3 | External Relief Depth | | 14 H | | 10 H | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | Ravi | | | |
| 5 | Material Sent For Hardening By (Name) | | | | Lark Furnace | | | |
| 6 | Material Sent For Hardening On Date | | 25 | 2 | 25 | | | |

Inspected By (Sign) & Date

Ravi 25/8/25

Reviewed by (Engineer-CNC)
 26/8/25

Manager-QA