

9259



# 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.		14010 ✓	57/86 ✓
2	Machined By		V.T.L. n/c Shop	Digital 13.0.930
3	Pallet Die No.		14026(10.0) n/c ✓	Row 08 ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 n/c, Step 0.0, 692.9 n/c	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 n/c (Bar = 548.4 n/c)	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.8 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 n/c   32 x 7 x 9.2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[ Face Side Step 2 n/c Raab Back Side ]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c ✓	[ Tapping No of holes = 2 Back Side ]
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.3 n/c Tapping	Depth 31.5 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/07/25

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

Counters: Go

1	Counter Sinking Depth & Finish	ok							Row = 8
2	External Relief Dia	11.0 n/c	All Rows						
3	External Relief Depth		9 n/c						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		27	2	25				

Inspected By (Sign) & Date

Ravi 27/07/25

Reviewed by (Engineer-CNC)  
27/7/25

Manager-QA