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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.		14301 ✓	37150 ✓
2	Machined By		V.T.L. M/C Shop	Digital TSC 978
3	Pallet Die No.		14191 (3.5) ✓	Rev 2.00
4	Die Category	Drg. No.	Ext outside	Lark Std.
5	Out Side Diameter	Drg. No.	619.8 mm	Step 12: 612
6	Inside Diameter	Drg. No.	520.12 mm	Step length: 18.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm   13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565 mm	Tapping No. of holes: 12 Both Side
13	Tapping Hole Diameter		M20	
14	Tapping On Second Side	Half pitch of 1st side	Check by M20 Bolt	
15	Tapping Hole Depth		Drill Depth: 20.3 mm	Tapping Depth: 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Sasi 10/3/25

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 - 1 Hole Closed

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

1	Counter Sinking Depth & Finish	ok						Counter: 60° K0.2-35
2	External Relief Dia	4.0 mm	Outside (3.3)		Inner			
3	External Relief Depth		17 mm		13 mm			
4	Inspection Done Before Hardening By (Name)				Sasi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			10	3	25		

### Inspected By (Sign) & Date

Sasi 10/3/25

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Reviewed by (Engineer-CNC)

Manager-QA