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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.		14331 ✓	38/50 ✓
2	Machined By		V.T.L. H/C Shop	Dr. No. 13.0 = 392
3	Pallet Die No.		14265 (4.0) H/C ✓	Res: 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/C, Step 00 = 500 H/C	Tapber: 10°
6	Inside Diameter	Drg. No.	420.12 H/C ✓	Step by H. 18 H/C
7	Width of Pellet Die	Drg. No.	158 H/C ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C / 12x8x3 H/C	
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 Hole 8 Both Side
12	Tapping PCD		455 H/C ✓	
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 19.5 H/C	Tapping Depth = 16.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 11/3/25*

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

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

1	Counter Sinking Depth & Finish	ok						Counter Bot Res: 20
2	External Relief Dia	0.5 H/C	Outside 22.22	Inner				
3	External Relief Depth		16 H/C	12 H/C				
4	Inspection Done Before Hardening By (Name)		<i>Ravi</i>					
5	Material Sent For Hardening By (Name)		<i>Lark Furnace</i>					
6	Material Sent For Hardening On Date		1	3	25			

Inspected By (Sign) & Date *Ravi 11/3/25*

*Satya*  
Reviewed by (Engineer-CNC) *31/3/25*

Manager-QA