

93/9



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.		14324	L10/60
2	Machined By		V.T.L. n/c Shop	Dr. H. K. G. = 747
3	Pallet Die No.		14150 (8.0) n/c	Rev 2.00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	7.20 n/c, Step OD = 6.93 n/c	Tapping 12
6	Inside Diameter	Drg. No.	6.00 ± 0.12 n/c	Step length = 2.0 n/c
7	Width of Pellet Die	Drg. No.	2.22 n/c	
8	Grooves as per Drawing	Drg. No.	1.2 x 1.0 x 7.5 n/c / 1.2 x 1.0 x 7.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 12 Back Side
12	Tapping PCD		6.40 n/c	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.3 n/c	Tapping Depth = 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/8/25

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 = 30

1	Counter Sinking Depth & Finish	ok									Row = 18
2	External Relief Dia	8.5 n/c	Outside (3-3)		Inner						
3	External Relief Depth		2.5 n/c		2.0 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			1	3	25					

Inspected By (Sign) & Date

Ravi 11/8/25

Satyam 31/3/25

Reviewed by (Engineer-CNC)

Manager-QA