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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.		14324 ✓	40/60 ✓
2	Machined By		V.T.L. H/c. Shop	Drg. No. L.S.O. 747
3	Pallet Die No.		14151 (8.0) H/c	Rev. 2.00 ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	7.20 H/c, Step 00, 693 H/c	Tabber 12
6	Inside Diameter	Drg. No.	6.00 ± 0.12 H/c	Step length 8 H/c
7	Width of Pellet Die	Drg. No.	22.2 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 H/c   12 x 10 x 7.5 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 holes 12 Both side
12	Tapping PCD		64.0 H/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 H/c	Tapping Depth 18.6
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 30
2	External Relief Dia	8.5 H/c	Outside 3-3	Inner				Row 2 18
3	External Relief Depth		2.5 H/c	2.0 H/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 11/3/25

Satyam 31/3/25

Reviewed by (Engineer-CNC)

Manager-QA