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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.		14325	34/42
2	Machined By		V.T.L. N/C Shop	Digital Lark 310
3	Pallet Die No.		13976 (3.2) ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.8 mm Step 002 490.8 mm	Step length 1.5
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm   12x8x3 mm	
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 8 Both Side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 - Checked by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 mm Tapping Depth 18.0	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 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

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

Count etc 60  
Row 2 23

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5 mm	80 Side 2.2	Inner			
3	External Relief Depth		10 mm	6 mm			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		10	3	25		

**Inspected By (Sign) & Date**

Ravi 10/3/25

Satyam 10/3/25

Reviewed by (Engineer-CNC)

Manager-QA