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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.		14280 ✓	38/42/60 ✓
2	Machined By		V.T.L. n/c Shop	Drilling No. 62.0.554
3	Pallet Die No.		14148(6.0) H4 ✓	Rev. 00 ✓
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	719.8 H4 ✓	Step 00, 691.8 Step length 19.5
6	Inside Diameter	Drg. No.	600.12 H4 ✓	
7	Width of Pellet Die	Drg. No.	222 H4 ✓	
8	Grooves as per Drawing	Drg. No.	36x10x7 H4 / 36x10x7 H4 ✓	
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 Both side
12	Tapping PCD		645 H4 ✓	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok ok	
15	Tapping Hole Depth		Drill Depth 20.2 H4	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/7/25

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. 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	6.5 H4 7.0 H4	6.5 H4	All Rows = 22 H4 ✓						
3	External Relief Depth		7.0 H4	All Rows = 12 H4 ✓						
4	Inspection Done Before Hardening By (Name)			Ravi						
5	Material Sent For Hardening By (Name)			Lark Furnace						
6	Material Sent For Hardening On Date			7	3	25				

Inspected By (Sign) & Date

Ravi 27/7/25

7/31/25

Reviewed by (Engineer-CNC)

Manager-QA