9367

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.		14355	30/40
2	Machined By		V.T.L M/c Shop	Drg No. Lark 9179 SSTD
3	Pallet Die No.		13203(3.0) MM	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 MM, Step OD 395 MM	Step length 4.5
6	Inside Diameter	Drg. No.	320.12 MM	
7	Width of Pellet Die	Drg. No.	142 MM	
8	Grooves as per Drawing	Drg. No.	15.5x7x2 MM / 15.5x7x2 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/c Shop	Tapping No. of Holes 8 Both Side
12	Tapping PCD		355 MM	
13	Tapping Hole Diameter		M16, Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 20.2 MM	Tapping Depth 18 MM
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 12/3/25	
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 - 2 Hole Closed	

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

1	Counter Sinking Depth & Finish	Ok						Counter 60° Rows 20
2	External Relief Dia	3.5 MM	Outside (2-2)		Inner			
3	External Relief Depth		13 MM		10 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		12	3	25			
	Inspected By (Sign) & Date		Ravi 12/3/25					

Satya 12/3/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner