

9371



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.		14343	45/50
2	Machined By		V.T.C. M/C Shop	Digit 1-20-9980
3	Pallet Die No.		14198 (6.0) M	Review
4	Die Category	Drg. No.	Part aside	
5	Out Side Diameter	Drg. No.	6.0mm Step 00. Tapper 12°	
6	Inside Diameter	Drg. No.	5.2±0.02 mm	Step length 12.5
7	Width of Pellet Die	Drg. No.	2.2±0.02 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		56.5 mm	[Tapping No. of holes 12 Both Side]
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 20.2 mm	Tapping Depth 18.6
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

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

Counter 60°
Lead 28

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5 mm	Outside (3.3)		Inner		
3	External Relief Depth		1.1 mm		5 mm		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Ravi		
6	Material Sent For Hardening On Date		12	3	25		

Inspected By (Sign) & Date

Ravi 10/3/25

Satya 12/3/25

Reviewed by (Engineer-CNC)

Manager-QA