

9359



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.		14354 ✓	41/65 ✓
2	Machined By		V. T. L. N/C Shop	Dy. No. 12.02788
3	Pallet Die No.		14561 (6.0) mm ✓	Rev. 1.01
4	Die Category	Drg. No.	N. Torque	
5	Out Side Diameter	Drg. No.	678 mm Step 002 692 mm ✓	Tabber 3° ✓
6	Inside Diameter	Drg. No.	546.12 mm (Box = 548.3 mm)	Step length 38 mm ✓
7	Width of Pellet Die	Drg. No.	195 mm	Under cut = 2.8 mm ✓
8	Grooves as per Drawing	Drg. No.	31x8x9.1 mm / 31x8x9.1 mm (5x8)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step 1mm Deep Back side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		619 mm ✓	Tapping No. of holes & Both Side
13	Tapping Hole Diameter		MIG - Check by MIG Ball ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 38.3 mm	Tapping Dept. 30.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 11/8/25

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 30°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	7.0 mm ✓	All Rows						
3	External Relief Depth		24 mm ✓						
4	Inspection Done Before Hardening By (Name)		Sasi						
5	Material Sent For Hardening By (Name)		Lark Porrace						
6	Material Sent For Hardening On Date		11	8	25				

Inspected By (Sign) & Date

Sasi 11/8/25

Reviewed by (Engineer-CNC)
Sasi 11/8/25

Manager-QA