

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9490

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.			
2	Machined By		14444 ✓	33/40 ✓
3	Pallet Die No.		V.T.L. H/c Shop	Dry H/c 12.02.25
4	Die Category	Drg. No.	14325 (3.0) H/c ✓	Rev. 00 ✓
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	390 H/c Step 002 383 H/c	Step length 11.5
7	Width of Pellet Die	Drg. No.	310.12 H/c	
8	Grooves as per Drawing	Drg. No.	135 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/c / 12x8x3 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		350 H/c	of H/c 8
13	Tapping Hole Diameter		03/4" - Check by 03/4" Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sai: 31/3/25	
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				
1	Counter Sinking Depth & Finish	ok		
2	External Relief Dia	3.3 H/c	20 Side (2.2)	Inner
3	External Relief Depth		13 H/c	7 H/c
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		31	3 25
Inspected By (Sign) & Date			Sai: 31/3/25	

Countersink 60
Rev. 20

Sai
31/3/25

Reviewed by (Engineer-CNC)

Manager-QA