

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.		13459	70/70
2	Machined By		V-T.L n/c Shop	Dy. No. 13.0 051
3	Pallet Die No.		13517 (4.0) n/c	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770 n/c Step 00. 748.4 n/c	Tapper 11°
6	Inside Diameter	Drg. No.	630.12 n/c	Step length 83 n/c
7	Width of Pellet Die	Drg. No.	265 n/c	
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c / 15x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of Hole 16 Both Side
12	Tapping PCD		685 n/c	
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 20.4 n/c Tapping Depth 18.6 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 11/12/24	
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 - 5 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Row 2 38
2	External Relief Dia	—	No Relief	
3	External Relief Depth	—	—	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Keshav	
6	Material Sent For Hardening On Date		11 12 24	
Inspected By (Sign) & Date			Ravi 11/12/24	

Reviewed by (Engineer-CNC) *[Signature]* 12/12/24

Manager-QA