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# 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.		13166	75/75
2	Machined By		V.T.L. H/c Shop	Dy No. 130,691
3	Pallet Die No.		14205 (8.2) H/c	Rev. 00
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1060.8 H/c	Step OD: 1040.8 H/c Tapper 4°
6	Inside Diameter	Drg. No.	911.2 H/c	911.2 H/c Step length 29 H/c
7	Width of Pellet Die	Drg. No.	388 H/c	
8	Grooves as per Drawing	Drg. No.	33x9.8x10 H/c	33x9.8x10.1 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step H/c
10	Drilling Area Surface Smoothness		ok	Deep Both Side
11	Tapping Operator		H/c Shop	Tapping No. of Holes 16
12	Tapping PCD		975 H/c	Both Side
13	Tapping Hole Diameter		M24, Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 40.4 H/c	Tapping Depth 38.4 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 31/1/25

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  
Row: 30

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	9.0 H/c	outside 23-35			
3	External Relief Depth		8 H/c			
4	Inspection Done Before Hardening By (Name)		Ravi			
5	Material Sent For Hardening By (Name)		Lark Fornare			
6	Material Sent For Hardening On Date		31	1	25	

**Inspected By (Sign) & Date**

Ravi 31/1/25

Satyam  
21/1/25

Reviewed by (Engineer-CNC)

Manager-QA