



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)

9072

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|-------------------------|--|
| 1 | Work Order No. | | 13887 ✓ | 50/50 ✓ |
| 2 | Machined By | | V.T.L. H/c Step | Dr. No. 1.2.0213760 |
| 3 | Pallet Die No. | | 14249 (8.0) ✓ | Row 00 ✓ |
| 4 | Die Category | Dr. No. | Senior | |
| 5 | Out Side Diameter | Dr. No. | 519.9 mm Step 00.491 mm | Step length 1.17 ✓ |
| 6 | Inside Diameter | Dr. No. | 420.12 mm | |
| 7 | Width of Pellet Die | Dr. No. | 158 mm ✓ | |
| 8 | Grooves as per Drawing | Dr. No. | 12x8x3 mm / 12x8x3 mm | |
| 9 | Fitting Sizes on CNC Plate | Dr. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | H/c Step | [Tapping No. of holes = 8 Both Side] |
| 12 | Tapping PCD | | 454 mm ✓ | |
| 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 18.3 mm | Tapping Depth 16.6 mm |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 25/1/25

| | | | |
|---|--------------------------------|--------|-------|
| 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

| | | | | | | | | | |
|---|--|--------|---------------|---|--------------|--|--|--|-----------------------|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | Counter = 60 Row = 12 |
| 2 | External Relief Dia | 8.3 mm | outside (2-2) | | inner | | | | |
| 3 | External Relief Depth | | 4 mm | | mill | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | Ravi | | | | |
| 5 | Material Sent For Hardening By (Name) | | | | Lark Furnace | | | | |
| 6 | Material Sent For Hardening On Date | | 25 | 1 | 25 | | | | |

Inspected By (Sign) & Date

Ravi 25/1/25

Reviewed by (Engineer-CNC)
Sethi 25/1/25

Manager-QA