

9091



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.		13958 ✓	26/4 ✓ 27/9
2	Machined By		V.T.L. n/c Shop	Dr. no. lost 23/10 ✓
3	Pallet Die No.		13217(4.0) ✓	
4	Die Category	Drg. No.	S&W	
5	Out Side Diameter	Drg. No.	499.6 ✓ Step 002 490 ✓	Step length 17.4 ✓
6	Inside Diameter	Drg. No.	420.12 ✓	
7	Width of Pellet Die	Drg. No.	182.1 ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 ✓ 12 x 8 x 3 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping no. of 4.1.2. 2 Both side
12	Tapping PCD		454 ✓	
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 18.2 ✓	Tapping Depth 16.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/1/25

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 2 25

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.5 ✓	outside (2.2)		inner			
3	External Relief Depth		18 ✓		14 ✓			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark furnace
6	Material Sent For Hardening On Date		27	1	25			

Inspected By (Sign) & Date

Ravi 27/1/25

Satish 27/1/25
Reviewed by (Engineer-CNC)

Manager-QA