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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.		1400 ✓	34/40 ✓
2	Machined By		V.T.V h/c Stop	Drg No. 1.3.0.23
3	Pallet Die No.		13218 (3.2) ✓	Revol ✓
4	Die Category	Drg. No.	SE 10	
5	Out Side Diameter	Drg. No.	499.9mm ✓ Step 00 = 490.9mm ✓	Step length 1.6 ✓
6	Inside Diameter	Drg. No.	420.12 mm ✓	
7	Width of Pellet Die	Drg. No.	173 mm ✓	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 mm / 10x8.5x5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		h/c Stop	Tapping No of holes = 8 Both Side
12	Tapping PCD		455 mm ✓	
13	Tapping Hole Diameter		φ3/4" = Check by φ3/4" Ball ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Dep. 20.2 mm ✓	Tapping Depth 18.8 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 29/1/25

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter 2 Go
2	External Relief Dia	3.8 mm ✓	20 Hole (2.2)	Inner				Rev: 27
3	External Relief Depth		10 mm ✓	6 mm ✓				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		29	1	25			

### Inspected By (Sign) & Date

Ravi 29/1/25

Sub 29/1/25

Reviewed by (Engineer-CNC)

Manager-QA