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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.		14115 ✓	45/50 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. 1.3.2 370
3	Pallet Die No.		14254 (G.O) ✓	Rev. 00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520mm ✓ Step 00 = 491mm ✓	Step length 19mm ✓
6	Inside Diameter	Drg. No.	420.12 mm ✓	12.5mm ✓
7	Width of Pellet Die	Drg. No.	159.5mm ✓	
8	Grooves as per Drawing	Drg. No.	13.5 x 8 x 3 mm   10 x 8 x 3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 8 Both Side
12	Tapping PCD		454mm ✓	
13	Tapping Hole Diameter		Ø 3/4" - Check by 1st Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3mm	Tapping Depth 16.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 3/2/25

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

Count 22 60° Row = 15

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5 mm	Outside (2-2)	Inner			
3	External Relief Depth		11 mm	5 mm			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Borneal				
6	Material Sent For Hardening On Date		3	2	25		

### Inspected By (Sign) & Date

Ravi 3/2/25

Satish 3/2/25

Reviewed by (Engineer-CNC)

Manager-QA