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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.		14123 ✓	23/40
2	Machined By		V.T.L. H/C Shop	Digital 1.8.0.15.02
3	Pallet Die No.		13043 (3.0) H/C ✓	20.00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm Step 00. 498	8mm Tapping ✓
6	Inside Diameter	Drg. No.	420.12 H/C ✓	Step Length 13mm ✓
7	Width of Pellet Die	Drg. No.	158 H/C ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3mm 12x8x3mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	[Tapping H of Holes P Back Side]
12	Tapping PCD		454 H/C ✓	
13	Tapping Hole Diameter		H20. Check by H20 Ball ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.3mm Tapping Depth 16.5mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Savi 5/2/25

1	As per programme no.		_____	Taper to straight fit
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

1	Counter Sinking Depth & Finish	OK								Savi 24
2	External Relief Dia	3.5mm	outside 02-27		Inner					
3	External Relief Depth		20mm		17mm					
4	Inspection Done Before Hardening By (Name)									Savi
5	Material Sent For Hardening By (Name)									Lark Porhace
6	Material Sent For Hardening On Date		5	2	25					
Inspected By (Sign) & Date		Savi 5/2/25								

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Reviewed by (Engineer-CNC)

Manager-QA