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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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14081	53/52
2	Machined By		V.T.L. H/C Shop	Dy. No. 1202/248
3	Pallet Die No.		13862 (d.o) H/C	Recess
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	634 H/C Step OD: 682 H/C	Step length: 17.5 H/C
6	Inside Diameter	Drg. No.	530.12 H/C	82 H/C
7	Width of Pellet Die	Drg. No.	278 H/C	Undercut = 24 H/C
8	Grooves as per Drawing	Drg. No.	43 x 8 x 8 H/C   27 x 8 x 8 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H/C of Holes: 8
12	Tapping PCD		594 H/C	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and	2nd Side One Side
15	Tapping Hole Depth		Drill Depth 25.3 H/C	Tapping Depth 23.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 19/2/25

1	As per programme no.			T Slot 29.1 H/C width 18 H/C Depth
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No - 15 Hole Closed	

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

1	Counter Sinking Depth & Finish	ok						Counter = 6° Ravi = 96
2	External Relief Dia							No Relief
3	External Relief Depth							
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		19	2	25			

**Inspected By (Sign) & Date**

Ravi 19/2/25

Ravi 19/2/25

Reviewed by (Engineer-CNC)

Manager-QA