

9/93



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.		14129	39/50
2	Machined By		V. T. L. N/C Shop	Dy. M. Lark
3	Pallet Die No.		13071 (3.5) mm	
4	Die Category	Drg. No.	SSS-10	
5	Out Side Diameter	Drg. No.	62mm, Step OD = 811.9 mm	Step length 9.5
6	Inside Diameter	Drg. No.	520.12 mm	
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		565 mm	Tapping Hole of Holes 12 Botm Side
13	Tapping Hole Diameter		M20, Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.3 mm Tapping Depth = 18.5 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/2/25

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

1	Counter Sinking Depth & Finish	ok							Counter etc. 60
2	External Relief Dia	4.0 mm	outside 3-3		Inner				Ravi 27
3	External Relief Depth		19 mm		11 mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Porrae
6	Material Sent For Hardening On Date			14	2	25			

Inspected By (Sign) & Date

Ravi 14/2/25

S. S. S. 14/2/25

Reviewed by (Engineer-CNC)

Manager-QA