

9196



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.		13633 ✓	40/40 ✓
2	Machined By		V.T.L. H/c Shop	Drg No. 1.3.02 474
3	Pallet Die No.		14358 (4.0) H/c ✓	Rev. 1.00 ✓
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	391 H/c Step 002 388 H/c	Step length 9.5
6	Inside Diameter	Drg. No.	311.12 H/c / 310.12 H/c (A)	
7	Width of Pellet Die	Drg. No.	146 H/c ✓	maintain in final sizes
8	Grooves as per Drawing	Drg. No.	15x8x3 H/c / 15x8x3 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of holes 8
12	Tapping PCD		356 H/c ✓	Back Side
13	Tapping Hole Diameter		0.315" / 0.12" = Check by 0.315" Ratt 0.315" Tap	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 H/c Tapping Depth 16.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raoi 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 = 60°
2	External Relief Dia	4.5 H/c	outside (2-2)	Inner			low = 17
3	External Relief Depth		4 H/c	Null			
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		14	2	25		

Inspected By (Sign) & Date

Raoi 14/2/25

Saty 14/2/25

Reviewed by (Engineer-CNC)

Manager-QA