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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.		14157 ✓	33/50 ✓
2	Machined By		V.T.L. NLC Shop	Dr. No. 180-985
3	Pallet Die No.		1355G (3.0) M4	Rev. 00 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 M4, Step 002 394 M4	Step length 200
6	Inside Diameter	Drg. No.	600.12 M4	Tapper 12°
7	Width of Pellet Die	Drg. No.	222 M4 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x7 M4 12x8x7 M4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		NLC Shop	Tapping No. of holes 12 Back side
12	Tapping PCD		640 M4 ✓	
13	Tapping Hole Diameter		M20: Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22.3 M4 Tapping Depth 20.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi 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 G Row: 39
2	External Relief Dia	3.5 M4	Outside (3-3)	Inner
3	External Relief Depth		2.3 M4	1.7 M4
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Portage	
6	Material Sent For Hardening On Date		14	25
Inspected By (Sign) & Date			Sasi 14/2/25	

Reviewed by (Engineer-CNC)
Sasi 14/2/25

Manager-QA