

9227



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.		13290	Bo/65
2	Machined By		V.T.C. n/c Shop	Dy. No. 18.92951
3	Pallet Die No.		14425(4.5)mm	Rev 200
4	Die Category	Dr. No.	Senior	
5	Out Side Diameter	Dr. No.	550mm Step OD: 49mm	Step length: 17.5mm
6	Inside Diameter	Dr. No.	42.12mm	
7	Width of Pellet Die	Dr. No.	158mm	
8	Grooves as per Drawing	Dr. No.	12x8x3mm 12x8x3mm	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 8 Back Side
12	Tapping PCD		454mm	
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: 18.3mm Tapping Depth: 16.6mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/2/25

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 Bo
2	External Relief Dia	5.0mm	outside (2-2)		Inner			Rev 218
3	External Relief Depth		14mm		5mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark furnace
6	Material Sent For Hardening On Date		18	2	25			

Inspected By (Sign) & Date

Ravi 18/2/25

Sats 18/2/25

Reviewed by (Engineer-CNC)

Manager-QA