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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.		14319 ✓	32/70 ✓
2	Machined By		M.T.L. H/O Shop	Dy. No. 12.02.977
3	Pallet Die No.		13350 (6.0) H/O	Recess
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 H/O Step 002 397.5 H/O	Tap hole 5°
6	Inside Diameter	Drg. No.	546.12 H/O (Box = 548.3)	Step length 38.5
7	Width of Pellet Die	Drg. No.	215 H/O	Undercut 1.8 H/O
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 9.1 H/O   29.5 x 10 x 9.1 H/O (R x 8) H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Place Side Step
10	Drilling Area Surface Smoothness		ok	1 H/O Deep Hole
11	Tapping Operator		H/O Shop	Side
12	Tapping PCD		618 H/O ✓	Tapping H/O
13	Tapping Hole Diameter		H/O = Check by H/O Ball	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth = 30.2 H/O	Tapping Depth 30.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Soni 2/8/25*

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 30
2	External Relief Dia	7.0 H/O	All	Ross					14
3	External Relief Depth			38 H/O					
4	Inspection Done Before Hardening By (Name)			Soni					
5	Material Sent For Hardening By (Name)			Lark furnace					
6	Material Sent For Hardening On Date		1	3	25				

Inspected By (Sign) & Date *Soni 1/8/25*

*Soni*  
31/3/25  
Reviewed by (Engineer-CNC)

Manager-QA