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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.		13853 ✓	60/60 ✓
2	Machined By		V.T.L. H/C Shop	Drilling 1.2.0.1.50
3	Pallet Die No.		14398 (3.0) H/C	Reo = 00 ✓
4	Die Category	Drg. No.	Jumbo (A31)	
5	Out Side Diameter	Drg. No.	750 H/C, Step OD, 745.4 H/C	Tappers 1.5
6	Inside Diameter	Drg. No.	630.12 H/C	Step length 2.2 H/C
7	Width of Pellet Die	Drg. No.	265 H/C	
8	Grooves as per Drawing	Drg. No.	15x8x5 H/C   15x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H/C of Holes, 1.8 Both Side
12	Tapping PCD		685 H/C	
13	Tapping Hole Diameter		H20, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.2 H/C	Tapping Depth. 18.6 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 28/2/25

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 - 7 Hole Closed (P)

**Note : Mark the defective holes/Missed holes with the help of Permanent Marker**

Counter 2.60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	—	—	No - Relief					
3	External Relief Depth	—	—	—					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Shri Keshav					
6	Material Sent For Hardening On Date			26	2	25			

**Inspected By (Sign) & Date**

Ravi 28/2/25

Reviewed by (Engineer-CNC)  
Sohal 27/2/25

Manager-QA