

9231



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.		14186 ✓	98/50 ✓
2	Machined By		V.T.L. N/C Shop	Drg No. 18.02 ✓
3	Pallet Die No.		14562 (2.8) ✓	Review ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760mm Step OD, 801mm	Tapper 2 9.5 ✓
6	Inside Diameter	Drg. No.	660.12mm ✓	Step length 20mm ✓
7	Width of Pellet Die	Drg. No.	316mm ✓	Undercut 2 20.5mm ✓
8	Grooves as per Drawing	Drg. No.	18x9x6mm 18x9x6mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		725mm	Tapping No. of holes 12 Both side
13	Tapping Hole Diameter		M2, Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.8mm Tapping Depth 20.5mm ✓	
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 6.0 ✓
2	External Relief Dia	3.3mm	Outside (3-3)	Inner			Review 59
3	External Relief Depth		25mm	22mm			
4	Inspection Done Before Hardening By (Name)		<i>Ravi</i>				
5	Material Sent For Hardening By (Name)		<i>Lark Forrace</i>				
6	Material Sent For Hardening On Date		18	2	25		

Inspected By (Sign) & Date *Ravi 18/2/25*

Satyam
18/2/25
Reviewed by (Engineer-CNC)

Manager-QA