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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.		14161	40/6/100
2	Machined By		V. T. L. H/O Shop	Dy. Insp. L. D. 28/9
3	Pallet Die No.		14397 (A.0) H/O	28/03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/O Step 0.2	692.8 H/O Tapper 8°
6	Inside Diameter	Drg. No.	546.12 H/O (Bore 548.4 H/O)	Step length 31 H/O
7	Width of Pellet Die	Drg. No.	195 H/O	Undercut 2.5 H/O
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 H/O	32 x 7 x 9.2 H/O
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step 2 H/O Deep Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	Tapping H/O of holes 2 Both Side
12	Tapping PCD		619 H/O	
13	Tapping Hole Diameter		MIG Check by H/O Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.3 H/O	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/7/25

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	6.5 H/O 7.0 H/O	6.5 H/O All Rows = 28 H/O						Row = 12
3	External Relief Depth		7.0 H/O All Rows = 6 H/O						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		25	2	25				
Inspected By (Sign) & Date			Ravi 25/7/25						

Reviewed by (Engineer-CNC)
S. S. 25/7/25

Manager-QA