

9219



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14191 ✓	27/66 ✓
2	Machined By		V.T.L. N/C Shop	Drill 1.3.9.320
3	Pallet Die No.		14495 (6.0) ✓	Rev 08 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 ✓	Step 00 = 692.9 ✓
6	Inside Diameter	Drg. No.	546.12 ✓	(Bor = 548.1 ✓)
7	Width of Pellet Die	Drg. No.	195 ✓	
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		619 ✓	
13	Tapping Hole Diameter		N/C ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.2 ✓	Tapping Depth = 31.7 ✓
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

Count = 30

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	1.0 ✓	All Rows						
3	External Relief Depth		39 ✓						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Perreel						
6	Material Sent For Hardening On Date		18	2	25				

Inspected By (Sign) & Date

Ravi 18/2/25

Ravi 18/2/25

Reviewed by (Engineer-CNC)

Manager-QA