

9275



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.		14164 ✓	45/100
2	Machined By		V.T.L. H/O Shop	Dy. Insp. 1302/243
3	Pallet Die No.		14270 (80) ✓	Rev 0203
4	Die Category	Drg. No.	Q 3. Jumbo	
5	Out Side Diameter	Drg. No.	1050.64 ✓ Step OD = 1041.8 ✓	Tabber = 4°
6	Inside Diameter	Drg. No.	851.12 ✓ (10 Step length 17 ✓)	Step length = 32.5 ✓
7	Width of Pellet Die	Drg. No.	251 ✓	Tabber = 15°
8	Grooves as per Drawing	Drg. No.	50x11x10.2 ✓	50x11x10.2 (A) ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tabber = 15°
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	Tapping dia of holes = 24 Rota Side
12	Tapping PCD		958 ✓	
13	Tapping Hole Diameter		M30 = Check by M30 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 43.5 ✓	Tapping Depth 41 ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 26/2/25

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 3° Row = 12
2	External Relief Dia	9.04 ✓	All Rows =						
3	External Relief Depth		45 ✓						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		26	2	25				

Inspected By (Sign) & Date

Ravi 26/2/25

Sats 26/2/25

Reviewed by (Engineer-CNC)

Manager-QA