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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.		14206	33/50
2	Machined By		V. T. L. H/C Shop	By No. 6-20-978
3	Pallet Die No.		14171(3.0) H/C	Rev. 00
4	Die Category	Dr. No.	Extra wide	
5	Out Side Diameter	Dr. No.	6.20 H/C	Step OD, Tapper 12°
6	Inside Diameter	Dr. No.	5.20 H/C	Step length 18.5
7	Width of Pellet Die	Dr. No.	2.22 H/C	
8	Grooves as per Drawing	Dr. No.	13x8x5 H/C	13x8x5 H/C
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H/C of 4.6.12 Retu Side
12	Tapping PCD		5.65 H/C	
13	Tapping Hole Diameter		H20, Check by H20 Roll	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 H/C	Tapping Depth 18.5 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/7/25

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 - 60°
2	External Relief Dia	13.5 H/C	outside 13-37		Inner			Rev. 38
3	External Relief Depth		23 H/C		17 H/C			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		22	2	25			

Inspected By (Sign) & Date

Ravi 22/7/25

Reviewed by (Engineer-CNC)

Manager-QA