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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.		14242	45/55
2	Machined By		V. T. L. n/c Shop	Dy. No. 12.2/107
3	Pallet Die No.		14122(5.0) n/c	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	709.8 n/c	Step 002 692.8 n/c Tapper 12°
6	Inside Diameter	Drg. No.	600.12 n/c	Step length 2 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12.8 x 7 n/c   12.8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		640 n/c	Tapping Holes of holes 12 Bore Side
13	Tapping Hole Diameter		42.2 Check by 42.2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 n/c	Tapping Depth 18.0 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Pavi 25/2/25

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 60
2	External Relief Dia	5.5 n/c	Outside (3-3)		Inner				Rev. 27
3	External Relief Depth		15 n/c		10 n/c				
4	Inspection Done Before Hardening By (Name)								Pavi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		25	2	25				

**Inspected By (Sign) & Date**

Pavi 25/2/25

Reviewed by (Engineer-CNC)

Manager-QA