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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.		14266	45/55
2	Machined By		V. T. L. n/c Step	Digital 1-20-809
3	Pallet Die No.		11905 (5.0) mm	200200
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	709.9 mm Step 002 709.9 mm	Tapper 4
6	Inside Diameter	Drg. No.	600.12 mm	Step length 28
7	Width of Pellet Die	Drg. No.	250 mm	
8	Grooves as per Drawing	Drg. No.	24x5x9 mm / 24x5x9 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Step	Tapping No. of Holes 12 Both Side
12	Tapping PCD		655 mm	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 24.2 mm Tapping Depth 28-6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 26/07/25*

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 mm	Outside (3-3)	Inner			Row 28
3	External Relief Depth		15 mm	10 mm			
4	Inspection Done Before Hardening By (Name)		<i>Ravi</i>				
5	Material Sent For Hardening By (Name)		<i>Lark Furnace</i>				
6	Material Sent For Hardening On Date		26	2	25		

Inspected By (Sign) & Date *Ravi 26/07/25*

Satya 27/7/25

Reviewed by (Engineer-CNC)

Manager-QA