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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.		14895	26/05/06
2	Machined By		V.T.L. n/c Shop	Dy. No. 1.8.0.230
3	Pallet Die No.		14500 (6.0) n/c	Revolok
4	Die Category	Drg. No.	n/c Jumbo	Carbide
5	Out Side Diameter	Drg. No.	680.1 n/c	Step OD = 693 n/c
6	Inside Diameter	Drg. No.	548.12 n/c	Step length = 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Width cut = 8.8 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 n/c	(4 x 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.1 n/c	ok
10	Drilling Area Surface Smoothness		ok	Face side Step 2 n/c Deep Pocket Side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	Tapping No. of Holes = 2 Both side
13	Tapping Hole Diameter		M16	
14	Tapping On Second Side	Half pitch of 1st side	Check by M16 Bolt	ok
15	Tapping Hole Depth		Drill Depth = 33.2 n/c	Tapping Depth = 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 7/3/25*

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 = 30 Rov = 12
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c	All Rows = 40 n/c					
3	External Relief Depth		7.0 n/c	All Rows = 30 n/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		7	3	25				

Inspected By (Sign) & Date *Ravi 7/3/25*

*Sats*  
7/3/25  
Reviewed by (Engineer-CNC)

Manager-QA