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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.		14208	34/47
2	Machined By		V. T. C. H/O Shop	Drilling 1.25mm 762
3	Pallet Die No.		14176 (3.2) mm	Rev 2.01
4	Die Category	Drg. No.	Front outside	
5	Out Side Diameter	Drg. No.	6.14 mm	Step 0.0, Grod. 6.4 mm, Tapper 12
6	Inside Diameter	Drg. No.	5.20 ± 0.12 mm	Step length 1.8 mm
7	Width of Pellet Die	Drg. No.	22.2 mm	Under cut 4.3 mm
8	Grooves as per Drawing	Drg. No.	13x8x5 mm   13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	Tapping No. of Holes 12 Both Side
12	Tapping PCD		56.5 mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 mm	Tapping Depth 18.5 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 28/2/25

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 - 1 Hole Closed (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.8 mm	Outside (3-3)		Inner				
3	External Relief Depth		17 mm		13 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		28	2	25				

### Inspected By (Sign) & Date

Ravi 28/2/25

Saty 28/2/25

Reviewed by (Engineer-CNC)

Manager-QA