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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.		13956	3-1-66
2	Machined By		V.T.C. H/c Shop	Dy No. 1209130
3	Pallet Die No.		14537 (3.5)mm	Rev. 01
4	Die Category	Drg. No.	3-Tumbo	
5	Out Side Diameter	Drg. No.	1032.3mm Step OD 1032.2mm	Tapper 2"
6	Inside Diameter	Drg. No.	900.12mm / 900.2mm	Step length 2.27mm
7	Width of Pellet Die	Drg. No.	375mm	Under cut 0.4mm
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13mm / 29.5 x 8 x 13mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes 15 (Both Side)
12	Tapping PCD		970mm	
13	Tapping Hole Diameter		M24 Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 38.2mm	Tapping Depth 26mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 11/3/25	2 Slot 32.1mm width 7.5mm Depth Both Side
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter 60 Ravi 59
2	External Relief Dia	4.0mm	Outside (4-4)	Inner
3	External Relief Depth		13mm	6mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Forrace	
6	Material Sent For Hardening On Date		11 3 25	
Inspected By (Sign) & Date			Ravi 11/3/25	

Reviewed by (Engineer-CNC)

Manager-QA