

91448



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.		14401 ✓	53/60 ✓
2	Machined By		V. T. L. H/C Shop	Drg. No. 1-30 915
3	Pallet Die No.		13780 (3.8) H/C	Rev. 2.00
4	Die Category	Drg. No.	9-222 H/C	
5	Out Side Diameter	Drg. No.	640 H/C Step OD 2815.5 H/C	Tapping 4"
6	Inside Diameter	Drg. No.	520 H/C	Step length 20 H/C
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H/C 13 x 8 x 5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H/C
12	Tapping PCD		565 H/C ✓	of Holes 12
13	Tapping Hole Diameter		H20. Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/C	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sai 28/3/25	
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 260
2	External Relief Dia	4.3 H/C	outside (3.3)	Rev. 33
3	External Relief Depth		14 H/C	7 H/C
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark Purpore	
6	Material Sent For Hardening On Date		22 3 25	
Inspected By (Sign) & Date			Sai 28/3/25	

Reviewed by (Engineer-CNC)

Manager-QA