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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.		14593	32/50
2	Machined By		V.T.L. H/C Shop	Dy H. 18.0.492
3	Pallet Die No.		14404 (4.0) H/C	Ren-200
4	Die Category	Drg. No.	M. Gunbo	
5	Out Side Diameter	Drg. No.	700 H/C	Step 02. 692.8 H/C
6	Inside Diameter	Drg. No.	600.2 H/C / 600.3 H/C (A)	Step length - 20 H/C
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12x10x7.4 H/C / 12x10x7.5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		H20, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.2 H/C	Tapping Depth - 18.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 8/1/25	
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 Sink
2	External Relief Dia	4.5 H/C	Outside 23-25	Inner 18 H/C
3	External Relief Depth		22 H/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		8/1/25	
Inspected By (Sign) & Date			Ravi 8/1/25	

Reviewed by (Engineer-CNC)

Manager-QA