

9551

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.		14432	50/69
2	Machined By		V.T.L. n/c Shop	54/69
3	Pallet Die No.		12308 (8.0) n/c	80.823
4	Die Category	Drg. No.	M. 7mm ho	Rev. 00
5	Out Side Diameter	Drg. No.	838 n/c, Step 02 841.78 n/c	Tabber 5
6	Inside Diameter	Drg. No.	700.12 n/c	Step length 28.5
7	Width of Pellet Die	Drg. No.	240 n/c	Under cut = 1.8 n/c
8	Grooves as per Drawing	Drg. No.	29 x 10 x 8 n/c / 29 x 10 x 8 n/c (3 x 8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side step
10	Drilling Area Surface Smoothness		OK	1mm Drill Bar
11	Tapping Operator		n/c Shop	Side Tapping n/c
12	Tapping PCD		765 n/c	of Holes & Both Side
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 30.2 n/c	Tapping Depth. 20.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Raw: 31/9/25	
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
2	External Relief Dia	9.0 n/c	1st Rod 19 n/c	2nd Rod 15 n/c
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)		Raw!	
5	Material Sent For Hardening By (Name)		Lark Furnace.	
6	Material Sent For Hardening On Date		23 5 25	
Inspected By (Sign) & Date			Raw: 31/9/25	

Reviewed by (Engineer-CNC)

Manager-QA