9592

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)

No.	Check Parameter	Specification	Observations	Remarks
	Work Order No.		14615	35/43
2	Machined By		V.T.L M/C Shop	Drg. No. 1.8D 1009 Rev. 00
3	Pallet Die No.		143 Go (4.5) mm	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	388.8 mm, Step OD: 388.8 mm Step length 10	
6	Inside Diameter	Drg. No.	313.12 mm	
7	Width of Pellet Die	Drg. No.	146 mm	
8	Grooves as per Drawing	Drg. No.	14 x 6 x 3 mm / 14 x 6 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/C. Shop	Tapping No of Holes = 8 Both Side
12	Tapping PCD		352 mm	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm Tapping Depth 18	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 10/4/25	
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

Counter Go Ravi = 17

1	Counter Sinking Depth & Finish	Ok						
2	External Relief Dia	5.0 mm	outside (2-2)		Inner			
3	External Relief Depth		13 mm		8 mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		10	4	25			
	Inspected By (Sign) & Date		Ravi 10/4/25					

Satya 10/4/25

Reviewed by (Engineer-CNC)

Manager-QA