9648

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.		14809	40/46
2	Machined By		V.T.L M/c Shop	Dy No. 13.0 x 104
3	Pallet Die No.		14728 (B.O) mm	Rework
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410 mm Step OD: 384 mm	Step length 10.5
6	Inside Diameter	Drg. No.	315.12 mm / 318.12 mm	
7	Width of Pellet Die	Drg. No.	134 mm	Rework
8	Grooves as per Drawing	Drg. No.	4x5x3 mm / 4x5x3 mm	After Final
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	M/C
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/c Shop	Tapping No of holes. 8 Both Side
12	Tapping PCD		350 mm	
13	Tapping Hole Diameter		01/2" Check by 01/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 18.4 mm	Tapping Depth 14 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 17/4/25	
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

1	Counter Sinking Depth & Finish	Ok						Rev: 13
2	External Relief Dia	6.5 mm	Outside (2.2)		Inner			
3	External Relief Depth		10 mm		6 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		17	4	25			
	Inspected By (Sign) & Date		Ravi 17/4/25					

17/4/25

Reviewed by (Engineer-CNC)

Manager-QA