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Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		14420 ✓	36/44/50 ✓
2	Machined By		V.T.L. H/O Shop	Dry H. 18.0.45 ✓
3	Pallet Die No.		14996(3.9) H/H	Renew ✓
4	Die Category	Drg. No.	7210	
5	Out Side Diameter	Drg. No.	730 H/H, Step 00, 743.5 H/H	Tappet 10 ✓
6	Inside Diameter	Drg. No.	830.12 H/H	Step length 23 H/H
7	Width of Pellet Die	Drg. No.	290 H/H	Under cut 6.75 H/H
8	Grooves as per Drawing	Drg. No.	15x8x5 H/H / 15x8x5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping H. of holes 16
12	Tapping PCD		685 H/H	Both Side
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/H	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 25/4/25	
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	Count 21.60	
2	External Relief Dia	3.5 H/H / 4.0 H/H	3.5 H/H All Rows 2 14 H/H	Count 50
3	External Relief Depth		4.0 H/H All Rows 2 6 H/H	
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark For race	
6	Material Sent For Hardening On Date		25	4 25
Inspected By (Sign) & Date			Sasi 25/4/25	

Reviewed by (Engineer-CNC)

Manager-QA