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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.		14820	26/45
2	Machined By		V.T.L. H/O Shop	Day No. 12.2.15
3	Pallet Die No.		14112 (3.0) H/O	Rev. 100
4	Die Category	Drg. No.	SSS70	
5	Out Side Diameter	Drg. No.	610 H/O	Step 001: 629.8 H/O
6	Inside Diameter	Drg. No.	520.12 H/O	Step length 20.1
7	Width of Pellet Die	Drg. No.	186 H/O	Tabber 12
8	Grooves as per Drawing	Drg. No.	13x8x3 mm / 13x8x3 mm	Undercut 6.8 H/O
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		565 H/O	
13	Tapping Hole Diameter		H20 - Check by H2 - B.1	Tapping H/O of holes 12
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 20.4 H/O	Tapping Depth 20.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter Go

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 H/O	Outside (2-3)		Inner				
3	External Relief Depth		22 H/O		19 H/O				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		25	4	25				

Inspected By (Sign) & Date

Ravi 25/4/25

Reviewed by (Engineer-CNC)

Manager-QA