9755

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.		14742	40/45
2	Machined By		V.T.L M/c Shop	Dy No. 18.02.1070
3	Pallet Die No.		15184 (8.0) mm	Record
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	394.9 mm, Step OD 385.9 mm	Step length 11.5
6	Inside Diameter	Drg. No.	304.12 mm (Bor. 305.12 mm)	
7	Width of Pellet Die	Drg. No.	144 mm	
8	Grooves as per Drawing	Drg. No.	16 x 8 x 6 mm / 16 x 8 x 6 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		353 mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rai 30/4/25	
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 Bor Rev. 9

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	8.5 mm	Outside (2.2)		Inner			
3	External Relief Depth		13 mm		5 mm			
4	Inspection Done Before Hardening By (Name)		Rai					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		30	4	25			
	Inspected By (Sign) & Date		Rai 30/4/25					

Satya 30/4/25

Reviewed by (Engineer-CNC)

Manager-QA