

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10838

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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.		16175	45/50, 355
2	Machined By		V.T.I. M/c Shop	Dry No 2 last 310
3	Pallet Die No.		15401(2.5)mm	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	6.20mm	Step oD = 6.11.9 Step length 19.5
6	Inside Diameter	Drg. No.	5.20.14mm	
7	Width of Pellet Die	Drg. No.	2.22mm	
8	Grooves as per Drawing	Drg. No.	1.3 x 8 x 5mm / 1.3 x 8 x 5mm	
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 = 12
12	Tapping PCD		56.5mm	Both Side
13	Tapping Hole Diameter		M2. Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4mm	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 10/10/25	
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 - 2 hole Colused	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter 2.0
2	External Relief Dia	3.0mm	Outside (2-3)	Row 2 43
3	External Relief Depth		1mm	5mm
4	Inspection Done Before Hardening By (Name)		Ravi Ravi Sanyal	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		10 10 25	
Inspected By (Sign) & Date			Ravi 10/10/25	

Reviewed by (Engineer-CNC)

Manager-QA