10162

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.		15314	36/40
2	Machined By		V.T.L. M/C Shop	Dy. No. 18.2400 Rec. 00
3	Pallet Die No.		15171 (3.0) MM	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 MM, Step OD 471.9 MM	
6	Inside Diameter	Drg. No.	420.14 MM	Step length 13.5
7	Width of Pellet Die	Drg. No.	159 MM	
8	Grooves as per Drawing	Drg. No.	7x7x5 MM / 7x7x5 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		455 MM	
13	Tapping Hole Diameter		03/4" - Check by 03/4" Ring	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22.5 MM	Tapping Depth 20.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Sai: 28/6/25	
1	As per programme no.		—	23 Nos. 20.1 MM width 7 MM Deep Both Side
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. Go. Sai. 25

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.5 MM	Outside 2.2		Inner			
3	External Relief Depth		10 MM		4 MM			
4	Inspection Done Before Hardening By (Name)		Sai					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		28	6	25			
	Inspected By (Sign) & Date		Sai: 28/6/25					

Satya 28/6/25.

Reviewed by (Engineer-CNC)

Manager-QA