

8905



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.		13070 ✓	35/45/55
2	Machined By		V.T.L. n/c. Shop	1 Diameter 18.00
3	Pallet Die No.		13402 (6.0) ✓	Rev: 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	709.9 ✓	Step 002 69.9 ✓
6	Inside Diameter	Drg. No.	600.12 ✓	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	36 x 10 x 7 ✓	36 x 10 x 7 ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c. Shop	
12	Tapping PCD		645 ✓	[Tapping H ₂ of holes: 12 Both Side]
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 ✓	Tapping Depth: 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/10/24

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 50

1	Counter Sinking Depth & Finish	OK							Rev: 16
2	External Relief Dia	6.5 ✓	7.0 ✓	All Rows	7.0 ✓	All Rows			
3	External Relief Depth	✓	20 ✓		10 ✓				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		18	10	24				

Inspected By (Sign) & Date

Ravi 18/10/24

18/10/24

Reviewed by (Engineer-CNC)

Manager-QA