9110

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.		13610	45/50
2	Machined By		V.T.L M/c Shop	Drg No. 18.2.289
3	Pallet Die No.		13657(6.0) MM	Rev. 00
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	620 MM, Step OD, 622.4 MM	Tapper 12
6	Inside Diameter	Drg. No.	520.12 MM / 520.14 MM (1)	Step length 19.5 MM
7	Width of Pellet Die	Drg. No.	222 MM	Under cut 1.2 MM
8	Grooves as per Drawing	Drg. No.	14x8x5 MM / 14x8x5 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 12 Both Side
12	Tapping PCD		565 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 22.3 MM	Tapping Depth 20.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 29/1/25	
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 Colused (2)	

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

1	Counter Sinking Depth & Finish	ok						Counter 6
2	External Relief Dia	6.5 MM	Outside (3.3)		Inner			Row 23
3	External Relief Depth		11 MM		5 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark furnace					
6	Material Sent For Hardening On Date		29	1	25			
	Inspected By (Sign) & Date		Ravi 29/1/25					

Satya 30/1/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner