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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.			
2	Machined By		13806	42/50
3	Pallet Die No.		V.T.L. H/C Shop	Dy No. 1.30-72
4	Die Category	Drg. No.	12414 (4.0) H/C	
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	700 H/C Step 00. 693 H/C	Step length 19.5
7	Width of Pellet Die	Drg. No.	600.12 H/C	
8	Grooves as per Drawing	Drg. No.	222 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	14x8x7 H/C / 14x8x7 H/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		640 H/C	Tapping no of holes = 12 Both Side
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/C	Tapping Depth 19.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 7/1/25	Final Fitting Size Dy No. 1.30-2498 Rev. 00
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				
1	Counter Sinking Depth & Finish	ok		Counter 27.6 Rev. 32
2	External Relief Dia	4.5 H/C	Outside (3-3)	Inner
3	External Relief Depth		12 H/C	8 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		7	25
Inspected By (Sign) & Date			Ravi 7/1/25	

Reviewed by (Engineer-CNC)
Sats 7/1/25

Manager-QA