

8906



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.		13733	55/55
2	Machined By		V. T. L. H/C Shop	Drg No. 130-869
3	Pallet Die No.		13353(5.0)H	Rev 200
4	Die Category	Drg. No.	5&10	
5	Out Side Diameter	Drg. No.	530 H/C Step 00. 491 H/C	Step length 17.5
6	Inside Diameter	Drg. No.	420.14 H/C	
7	Width of Pellet Die	Drg. No.	182 H/C	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/C 12 x 8 x 3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping W. of holes = 8 Botu side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		H20, Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 H/C	Tapping Depth - 16.8 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 6/1/25

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

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

1	Counter Sinking Depth & Finish	ok						Counter 60
2	External Relief Dia	5.5 H/C	Outside (2-2)	Inner				
3	External Relief Depth		4 H/C	Mill				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		6	1	25			

Inspected By (Sign) & Date Ravi 6/1/25

Setu
7/1/25

Reviewed by (Engineer-CNC)

Manager-QA