8904

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.		13304	36/45
2	Machined By		V.T.L. H/C Shop	Dy No. 1.3.9. 958 Rev. 00
3	Pallet Die No.		14211 (B.O) HH	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395 HH, Step OD 383 HH, Step length 33 HH	
6	Inside Diameter	Drg. No.	304.12 HH / 305.12 HH (Rev. 305.12)	
7	Width of Pellet Die	Drg. No.	100 HH	Rework Step FD in Final Size
8	Grooves as per Drawing	Drg. No.	10 x 7 x 4 HH / 10 x 7 x 4 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		H/C Shop	Tapping No. of Holes 8 Both Side
12	Tapping PCD		349 HH	
13	Tapping Hole Diameter		M12 - Check by M12 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 HH Tapping Depth 19.6 HH	
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						Ravi 14
2	External Relief Dia	3.5 HH	Out Side (2-2)		Inner			
3	External Relief Depth		15 HH		9 HH			
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					

Satya 7/1/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner