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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.		13781	20/45
2	Machined By		N.T.L. H/c Shop	Qty No. 13.2 483
3	Pallet Die No.		13860 (5.0) H	Rev: 03
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 H H Step OD = 387 H H	Step length 10.5
6	Inside Diameter	Drg. No.	310.12 H	
7	Width of Pellet Die	Drg. No.	134 H H	
8	Grooves as per Drawing	Drg. No.	8x7x3 H H / 8x7x3 H H	
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		350 H H	
13	Tapping Hole Diameter		1/2" 2 Check by 1/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Robdr. 16.2 H H	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date		Ravi 7/11/25	
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

		Counter 60°				Rev: 15	
1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.5 H H	Outside (2-2)		Inner		
3	External Relief Depth		20 H H		15 H H		
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	1	25		

Inspected By (Sign) & Date		Ravi 7/11/25	
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Reviewed by (Engineer-CNC) *Ravi 7/11/25*

Manager-QA