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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.		13896	32/40
2	Machined By		V.T.L H/c Shop	Drill No. 13.2.942
3	Pallet Die No.		13717 (3.0) H/c	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	600 H/c, Step 00, 601.5 H/c	Tapper 12
6	Inside Diameter	Drg. No.	520.12 H/c 520.14 H/c	Step length 31.5
7	Width of Pellet Die	Drg. No.	222 H/c	Under cut = 10.75
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c. Shop	Tapping H/c of holes, 12 Botm Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Rept. 20.2 H/c	Tapping Depth 18.5 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 11/12/5

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 Row 37
2	External Relief Dia	3.3 H/c	All Rows					
3	External Relief Depth		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		11	1	25			

Inspected By (Sign) & Date Ravi 11/12/5

Reviewed by (Engineer-CNC) 13/11/25

Manager-QA