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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.		13930 ✓	58/55 ✓
2	Machined By		V. T. L. H/C Shop	Dy. No. 1.2.01/1724
3	Pallet Die No.		13581(3.5) H/C ✓	Rev 2.00 ✓
4	Die Category	Drg. No.	9 x 12.9 wide	
5	Out Side Diameter	Drg. No.	630 H/C ✓ Step 00.612 H/C	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/C ✓	
7	Width of Pellet Die	Drg. No.	222 H/C ✓	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H/C / 13 x 8 x 5 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 Both Side
12	Tapping PCD		565 H/C ✓	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/1/25

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

Counter = 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.0 H/C	Outside (3.3)		Inner				
3	External Relief Depth		10 H/C		3 H/C				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Porrace				
6	Material Sent For Hardening On Date		13	1	25				

Inspected By (Sign) & Date

Ravi 13/1/25

Reviewed by (Engineer-CNC)
S. S. S. 31/1/25

Manager-QA