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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.		13944	33/50
2	Machined By		V.T.L. H/O Shop	Drg No. 1.502973
3	Pallet Die No.		13720 (3.5) H/O	Rev 2.00
4	Die Category	Drg. No.	2nd side	
5	Out Side Diameter	Drg. No.	319.8 H/O Step 50. Tapper 12°	
6	Inside Diameter	Drg. No.	52.12 H/O	Step length 12.5
7	Width of Pellet Die	Drg. No.	222 H/O	
8	Grooves as per Drawing	Drg. No.	1378x5 H/O 1378x5 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping H/O of holes 12 Back side
12	Tapping PCD		56.5 H/O	
13	Tapping Hole Diameter		H2.2 Check by H2.2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/O Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/1/25

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

Counters No:

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.0 H/O	Outside (3-3)		Inner				
3	External Relief Depth		16 H/O		12 H/O				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		14	1	25				

Inspected By (Sign) & Date

Ravi 14/1/25

Reviewed by (Engineer-CNC)
Sathy 14/1/25

Manager-QA