

8993



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13960	33/50
2	Machined By		V.T.L. H/c Shop	6355 Dy. Mgr. Lark
3	Pallet Die No.		13677(3.0)mm	
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	620mm	Step length 19.5
6	Inside Diameter	Drg. No.	520.12mm	
7	Width of Pellet Die	Drg. No.	229mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565mm	Tapping dia of holes 12 Both Side
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 20.2mm	Tapping Depth 18.6mm
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 - 2 Hole Colused

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counters 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3mm	Outside (3-3)		Inner				
3	External Relief Depth		2.3mm		17mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Burnage
6	Material Sent For Hardening On Date			14		25			

Inspected By (Sign) & Date

Ravi 14/1/25

14/1/25

Reviewed by (Engineer-CNC)

Manager-QA