

9047



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.		13980 ✓	30/60
2	Machined By		V.T.L H/c Shop	Digital 1.3.02 1342
3	Pallet Die No.		13407 (3.0) H/c	Rev 100
4	Die Category	Drg. No.	H. Tombo	
5	Out Side Diameter	Drg. No.	671 H/c Step OD, 673 H/c	Tapper = 12
6	Inside Diameter	Drg. No.	551.12 H/c	Step length, 3 H/c
7	Width of Pellet Die	Drg. No.	235 H/c ✓	Under cut = 1 H/c
8	Grooves as per Drawing	Drg. No.	24.5 x 8 x 10 H/c 24.5 x 8 x 10 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		620 H/c ✓	Tapping No. of Holes = 8 Both Side
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 Depth 28.2 H/c	Tapping Depth 26.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/1/25

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

1	Counter Sinking Depth & Finish	ok							Counter 20.65
2	External Relief Dia	—	—	10	Relief				Rows 37
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Porrace				
6	Material Sent For Hardening On Date			22	1	25			

Inspected By (Sign) & Date

Ravi 22/1/25

Reviewed by (Engineer-CNC)
22/1/25

Manager-QA