

9059



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.		13884 ✓	30/10 ✓
2	Machined By		V.T.L n/a Shop	Dr. No. 13.0.878
3	Pallet Die No.		13859 (3-5) ✓	Rev. no ✓
4	Die Category	Dr. No.	Junior	
5	Out Side Diameter	Dr. No.	389.8 ✓	
6	Inside Diameter	Dr. No.	310.12 ✓	Step length 11.5
7	Width of Pellet Die	Dr. No.	144 ✓	
8	Grooves as per Drawing	Dr. No.	10x7x4 ✓	
9	Fitting Sizes on CNC Plate	Dr. No.	10x7x4 ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/a Shop	Tapping No of holes 8 Both Side
13	Tapping Hole Diameter		350 ✓	
14	Tapping On Second Side	Half pitch of 1st side	M16 - Check by M16 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.2 ✓	Tapping Depth 18.6 ✓
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 23/1/25

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							Condense Ro
2	External Relief Dia	4.0 ✓	Outside (2-2)	Inner					Row 2
3	External Relief Depth		14 ✓	10 ✓					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Ferrace
6	Material Sent For Hardening On Date		23	1	25				

Inspected By (Sign) & Date

Ravi 23/1/25

Satyam 23/1/25

Reviewed by (Engineer-CNC)

Manager-QA