

9078



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.		13931	56/58
2	Machined By		V.T.L. H/c Shop	Drg No. 6205986
3	Pallet Die No.		13273(4.0) H/H	Rev. 00
4	Die Category	Drg. No.	Tumbo	
5	Out Side Diameter	Drg. No.	776 H/H, Step 00 = 799.8 H/H	Setch length = 96 H/H
6	Inside Diameter	Drg. No.	660.12 H/H	Lead in cut = 12 H/H
7	Width of Pellet Die	Drg. No.	316 H/H	
8	Grooves as per Drawing	Drg. No.	20x8x7.5 H/H / 20x8x7.5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		725 H/H	
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 = 25.3 H/H Tapping Depth = 23.5 H/H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/1/25

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							Row = 46
2	External Relief Dia	4.5 H/H	Outside (3-3)		Inner				
3	External Relief Depth		10 H/H		2 H/H				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		25	1	25				

Inspected By (Sign) & Date

Ravi 25/1/25

Satyam 25/1/25

Reviewed by (Engineer-CNC)

Manager-QA