

9061



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.			
2	Machined By		13830 ✓	45/50 ✓
3	Pallet Die No.		V.T.L n/c Shop	Dy No. 1-20/3760
4	Die Category	Drg. No.	14248 (6.0) n/c ✓	Rev. 00 ✓
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	519.5 n/c (A) Step OD = 491 n/c	Step length = 17.5
7	Width of Pellet Die	Drg. No.	420.12 n/c ✓	
8	Grooves as per Drawing	Drg. No.	158 n/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c / 12x8x3 n/c ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c ✓	Tapping No. of Holes = 8 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 = 18.2 n/c	Tapping Depth = 16.8 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24/1/25

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 = 60
2	External Relief Dia	6.5 n/c	outside (2-2)		Inner			Len = 15
3	External Relief Depth		11 n/c		5 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Pur n/c
6	Material Sent For Hardening On Date		24	1	25			
Inspected By (Sign) & Date		Ravi 24/1/25						

Gatya 24/1/25

Reviewed by (Engineer-CNC)

Manager-QA