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# 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.		13965 ✓	40/40 ✓
2	Machined By		V.T.C. H/C Shop	Dy. No. 18/01/15-62
3	Pallet Die No.		13305 (3.5) H/C	Revised ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C ✓ Step on 498.88	Tapper 12°
6	Inside Diameter	Drg. No.	420.12 H/C	Step length 8 H/C
7	Width of Pellet Die	Drg. No.	158 H/C ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/C / 12 x 8 x 3 H/C	
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 8 Both Side
12	Tapping PCD		454 H/C	
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 H/C	Tapping Depth 16.6 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 27/1/25

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**

Count 2260

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.0 H/C	outside (2-2)		Inner			
3	External Relief Depth		4 H/C		Nil			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Barnace			
6	Material Sent For Hardening On Date		27	1	25			

**Inspected By (Sign) & Date**

Ravi 27/1/25

Ravi 27/1/25

Reviewed by (Engineer-CNC)

Manager-QA