

9073



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.		13829 ✓	45/50 ✓
2	Machined By		V.T.L. N/C Shop	Digital Length 137.60
3	Pallet Die No.		14246 (G.O) ✓	Raw = 00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.7 ✓	Step 00 = 496.7 ✓
6	Inside Diameter	Drg. No.	420.12 ✓	Step length 12.5 ✓
7	Width of Pellet Die	Drg. No.	158 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 ✓	12x8x3 ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C. Shop	Tapping of holes B Both side
12	Tapping PCD		454 ✓	
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 18.3 ✓	Tapping Depth 16.6 ✓
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

Count as per Raw = 15

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5 ✓	Outside (2-2)		Inner		
3	External Relief Depth		11 ✓		5 ✓		
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

Ravi 25/1/25

Reviewed by (Engineer-CNC)

Manager-QA