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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
 Rev. Date 31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14017	57/66
2	Machined By		V.T.C. H/O Shop	Drg No. 1.8.0.2.830
3	Pallet Die No.		14014 (10.0) H/O	Row: 08
4	Die Category	Drg. No.	M. Tumbo	
5	Out Side Diameter	Drg. No.	680.1 H/O Step 00: 693 H/O	Tappers 8"
6	Inside Diameter	Drg. No.	548.12 H/O (Box = 548.12 H/O)	Step length: 31 H/O
7	Width of Pellet Die	Drg. No.	195 H/O	Under cut: 2.8 H/O
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/O	(4 x 8) H/O
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Face side Step 2 H/O Deep Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		619 H/O	[Tapping No of Holes: 2 Both side]
13	Tapping Hole Diameter		N16 = Check by N16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 33.3 H/O	Tapping Depth: 31.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi: 28/1/25

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								
2	External Relief Dia	11.0 H/O	All	Rows						
3	External Relief Depth			9 H/O						
4	Inspection Done Before Hardening By (Name)			Ravi						
5	Material Sent For Hardening By (Name)			Lark Fornare						
6	Material Sent For Hardening On Date		28	1	25					

Inspected By (Sign) & Date

Ravi: 28/1/25

Satyam
28/1/25

Reviewed by (Engineer-CNC)

Manager-QA