9182

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.		14155	33/40
2	Machined By		V.T.L N/C Shop	Dwg No. 13.0.400 Rev 00
3	Pallet Die No.		13313 (4.0) HH	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 HH, Step OD. 491.8 HH	Step length 18.5
6	Inside Diameter	Drg. No.	420.12 HH	
7	Width of Pellet Die	Drg. No.	159 HH	
8	Grooves as per Drawing	Drg. No.	7 x 7 x 5 HH | 7 x 7 x 5 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		N/C Shop	Tapping No of holes 8 Both Side
12	Tapping PCD		455 HH	
13	Tapping Hole Diameter		Ø3/4" - Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 22.3 HH Tapping Depth 20.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 13/2/25	
1	As per programme no.		—	2 Slot 20 HH width 7 HH Deep Both Side
2	Gun Drilling Work Completed On		—	
3	Hole Finish In Gun Drilling	Marked	Ok	
4	Defective Holes (If Any)		No — 1 Hole Colosed (A)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter Gun Drill 21

1	Counter Sinking Depth & Finish	Ok						
2	External Relief Dia	4.5 HH	Outside (2 - 22)		Inner			
3	External Relief Depth		6 HH		2 HH			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Forge					
6	Material Sent For Hardening On Date		13	2	25			
	Inspected By (Sign) & Date		Ravi 13/2/25					

Satyam 13/2/25
Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner