9240

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.		14038 ✓	40/46 ✓
2	Machined By		V.T.L. H/C Shop	Dy No: 1.3.0.975
3	Pallet Die No.		14082 (6.0) HM ✓	Rev-00 ✓
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410 HM ✓ Step OD: 383 HM, Step length 5	
6	Inside Diameter	Drg. No.	318.12 HM ✓	
7	Width of Pellet Die	Drg. No.	108 HM ✓	
8	Grooves as per Drawing	Drg. No.	4x5x3 HM | 4x5x3 HM ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		HK Shop	Tapping No of holes: 8 Both Side
12	Tapping PCD		350 HM ✓	
13	Tapping Hole Diameter		M12" = Check by M12" Tap ✓	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth: 12.3 HM	Tapping Depth: 10.5 ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 19/2/25	
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						Row = 11
2	External Relief Dia	6.5HM ✓	Out Side Ø2.27		Inner			
3	External Relief Depth		10 HM		6 HM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		19	2	25			
	Inspected By (Sign) & Date		Ravi 19/2/25					

Satish 19/2/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner