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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.		14177	415/55
2	Machined By		V.T.L. H/c Shop	Dy. No. 1302/011
3	Pallet Die No.		12803 (8.0) H/c	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	740 H/c ✓ Step 002 738.5 H/c	Tappes 12
6	Inside Diameter	Drg. No.	630.12 H/c	Step length 23 H/c
7	Width of Pellet Die	Drg. No.	250 H/c	
8	Grooves as per Drawing	Drg. No.	17x8x7 H/c / 17x8x7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		680 H/c	Tapping No of holes 12 Both Side
13	Tapping Hole Diameter		N202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 25.3 H/c	Tapping Depth 23.6
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							
2	External Relief Dia	8.5 H/c	20 Side (3-3)		Inner				
3	External Relief Depth		18 H/c		10 H/c				
4	Inspection Done Before Hardening By (Name)								
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

Satyam 19/2/25

Reviewed by (Engineer-CNC)

Manager-QA