

9279



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.		14257	32/42/50
2	Machined By		V. T. L. H/c Shop	Dy. No. 13.0.259
3	Pallet Die No.		14186(4.0) H/c	Row 02
4	Die Category	Drg. No.	2 side wide	
5	Out Side Diameter	Drg. No.	62 H/c, Step 00, 62.2 H/c	Tabber 12
6	Inside Diameter	Drg. No.	52.12 H/c	Step length 18 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	Under cut 1.2 H/c
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 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		565 H/c	
13	Tapping Hole Diameter		M20, Check by H20 Bolt	[Tapping No. of H. loc. 12 Both Side]
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24/2/25

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

1	Counter Sinking Depth & Finish	ok						Counter 60
2	External Relief Dia	4.5 H/c 5.0 H/c	4.5 H/c	All Rows = 18 H/c				Row 31
3	External Relief Depth		5.0 H/c	All Rows = 8 H/c				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		24	2	25			

Inspected By (Sign) & Date

Ravi 24/2/25

Sator 24/2/25

Reviewed by (Engineer-CNC)

Manager-QA