

9024

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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14499 ✓	36/50 ✓
2	Machined By		V.T.L. H/c Shop	8355
3	Pallet Die No.		14466 (4.0) ✓	Dry H/c Shop
4	Die Category	Drg. No.	Endrenside	
5	Out Side Diameter	Drg. No.	6.2 mm Step 0.2 31.7 mm	Step length 19.5
6	Inside Diameter	Drg. No.	5.2 mm	
7	Width of Pellet Die	Drg. No.	22.2 mm	
8	Grooves as per Drawing	Drg. No.	13 x 2 x 5 mm / 13 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of holes 212 Both Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/4/25

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 - 2 Holes Colored

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

1	Counter Sinking Depth & Finish	ok								Power - 60
2	External Relief Dia	4.5 mm	8.2 - 35	Inner						
3	External Relief Depth		18 mm	14 mm						
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		13	4	25					

Inspected By (Sign) & Date

Ravi 13/4/25

Reviewed by (Engineer-CNC)

Manager-QA