

8902



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.		13332	05/51
2	Machined By		V. T. L. H/c Shop	Dr. No. 1.3.2.1198
3	Pallet Die No.		14203 (B.10) H/H	Rev. No.
4	Die Category	Drg. No.	Junbo	
5	Out Side Diameter	Drg. No.	802 H/H / Step 02-823 H/H	Tapping 4
6	Inside Diameter	Drg. No.	700.12 H/H	Step Length 3.2 H/H
7	Width of Pellet Die	Drg. No.	324.2 H/H	Undercut 10.5 H/H
8	Grooves as per Drawing	Drg. No.	30x8x8.5 H/H / 30x8x8.5 H/H	
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 Hole 12 Both Side
12	Tapping PCD		760 H/H	
13	Tapping Hole Diameter		H22 - Check by H22 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 36.2 H/H	Tapping Depth 34.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/1/25

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 - 1 Hole Closed

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	3.5 H/H	outside (3-3)		Inner				
3	External Relief Depth		21 H/H		15 H/H				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date				6	1	25		

Inspected By (Sign) & Date

Ravi 8/1/25

Reviewed by (Engineer-CNC)

Manager-QA