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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
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14031	410/50
2	Machined By		N.T.L H/c Shop	Dr. H. S. Lark 9510
3	Pallet Die No.		13732(4.0)mm	
4	Die Category	Dr. No.	External	
5	Out Side Diameter	Dr. No.	619.8 mm Step 0.02 611.8 mm	Step length 19.4
6	Inside Diameter	Dr. No.	520.12 mm	
7	Width of Pellet Die	Dr. No.	222 mm	
8	Grooves as per Drawing	Dr. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H. of Hole 12 Back 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 20.2 mm	Tapping Depth 18.6 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 13/1/25

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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

Cooper, G. S. 31

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.3 mm	Outside (3-3)	Inner			
3	External Relief Depth		14 mm	10 mm			
4	Inspection Done Before Hardening By (Name)		Sasi				
5	Material Sent For Hardening By (Name)		Lark Forcage				
6	Material Sent For Hardening On Date		13	1	25		

Inspected By (Sign) & Date

Sasi 13/1/25

Reviewed by (Engineer-CNC)
Sasi 13/1/25

Manager-QA