

9081



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.		13883	29/40
2	Machined By		V.T.L. H/c Shop	Drg No. Lark 3510
3	Pallet Die No.		13228(3.0) H/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c / 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes - 8 Both Side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 H/c	Tapping Depth 16 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/1/25

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

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/c	Outside (2-2)	Inner				
3	External Relief Depth		14 H/c	11 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		25	1	25			

Inspected By (Sign) & Date

Ravi 25/1/25

Saton 25/1/25

Reviewed by (Engineer-CNC)

Manager-QA