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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.		14017	57/66
2	Machined By		V.T.L. H/c Shop	Dy. No. 1.8.D. 330
3	Pallet Die No.		14016 (10.0) H/c	Rev. 08
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/c	Step OD 393 H/c
6	Inside Diameter	Drg. No.	546.12 H/c	Step length 9 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c	(4 x 8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Fore side Step
11	Tapping Operator		H/c Shop	2 H/c Deep Both Side
12	Tapping PCD		619 H/c	Tapping No. of holes 2
13	Tapping Hole Diameter		H16 = Check by H16 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.3 H/c	Tapping Depth 31.4 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 28/1/25

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

1	Counter Sinking Depth & Finish	ok					Count on 60
2	External Relief Dia	11.0 H/c	All Rows				Row 8
3	External Relief Depth		9 H/c				
4	Inspection Done Before Hardening By (Name)		Sasi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		28	1	25		

Inspected By (Sign) & Date

Sasi 28/1/25

Reviewed by (Engineer-CNC)
 Sasi 28/1/25

Manager-QA