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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14022	48/55
2	Machined By		V.T.L. H/O Shop	Dy No. 620/1924
3	Pallet Die No.		13584 (4.0) H/H	Rev 200
4	Die Category	Drg. No.	End outside	
5	Out Side Diameter	Drg. No.	629.9 H/H	Step 00 = 612 H/H Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/H	(Bar: Tapper: 0.3 H/H)
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x3x5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	Tapping No. of holes 12 Both side
12	Tapping PCD		565 H/H	
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: 20.2 H/H	Tapping Depth: 18.8 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 30/1/25

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	4.5 H/H	Outside (3-3)		Inner				
3	External Relief Depth		15 H/H		7 H/H				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Surface				
6	Material Sent For Hardening On Date		30		25				

Inspected By (Sign) & Date

Ravi 30/1/25

Satish 30/1/25

Reviewed by (Engineer-CNC)

Manager-QA