

9232



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.		14070 ✓	33/40
2	Machined By		V.T.L. H/c Shop	Dry No. Lark 3990
3	Pallet Die No.		13198 (3.5) H/c ✓	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	399.8 H/c Step O.D. 394.8 H/c	Step length 12.5
6	Inside Diameter	Drg. No.	320.12 H/c ✓	
7	Width of Pellet Die	Drg. No.	142 H/c ✓	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/c 15.5 x 7 x 2 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 Rota Side
12	Tapping PCD		355 H/c ✓	
13	Tapping Hole Diameter		M16, Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 H/c Tapping Depth 18.6 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 17/2/25*

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					Counter = 6.0 Lead = 18	
2	External Relief Dia	4.0 H/c	outside 22.25	Inner				
3	External Relief Depth		15 H/c	12 H/c				
4	Inspection Done Before Hardening By (Name)		<i>Ravi</i>					
5	Material Sent For Hardening By (Name)		Lark Rorace					
6	Material Sent For Hardening On Date		17	2	25			

Inspected By (Sign) & Date *Ravi 17/2/25*

Satya
19/2/25
Reviewed by (Engineer-CNC)

Manager-QA