

9225

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.			
2	Machined By		14233	24/40
3	Pallet Die No.		V.T.L. n/c Shop	Dy No. Lark 3310
4	Die Category	Drg. No.	13199 (3.5) n/c	
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	400 mm, Step OD: 395 mm	Step length = 14.5
7	Width of Pellet Die	Drg. No.	320.12 mm	
8	Grooves as per Drawing	Drg. No.	142 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	15.5 x 7 x 2 mm 15.5 x 7 x 2 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of holes & Reta Side
13	Tapping Hole Diameter		355 mm	
14	Tapping On Second Side	Half pitch of 1st side	n/c = Check by HIG Bolt	
15	Tapping Hole Depth		ok	Drill Depth: 20.3 mm Tapping Depth: 18.6 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/2/25

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. 60
2	External Relief Dia	4.0 mm	Outside (2-2)	Inner				Loose 18
3	External Relief Depth		19 mm	16 mm				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		18	2	25			

Inspected By (Sign) & Date

Ravi 18/2/25

Sats 18/2/25

Reviewed by (Engineer-CNC)

Manager-QA