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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.			
2	Machined By		14245 ✓	38140 / 3175
3	Pallet Die No.		V.T.L H/C Shop	Dy. H.C. Lark 3310
4	Die Category	Drg. No.	13974(3.5) H-C	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	499.9 H-C, Step 002 490.8 H-C	Step length 17.4
7	Width of Pellet Die	Drg. No.	400.12 H-C	
8	Grooves as per Drawing	Drg. No.	158 H-C	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H-C / 12x8x3 H-C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	
13	Tapping Hole Diameter		454 H-C ✓	[Tapping H.C. of Holes 8 Both Side]
14	Tapping On Second Side	Half pitch of 1st side	H202 Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 18.3 H-C, Tapping Depth = 16.6 H-C	
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

Inspected By (Sign) & Date

Ravi 22/2/25

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 H-C	Outside (2-2)		Inner			Low 2.2
3	External Relief Depth		8 H-C		2 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		22	2	25			
Inspected By (Sign) & Date		Ravi 22/2/25						

Saty 24/2/25

Reviewed by (Engineer-CNC)

Manager-QA