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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.		14260	36/44/50
2	Machined By		V.T.L. H/c Shop	Dy. No. 1205
3	Pallet Die No.		13876(3.0) H/c	Rev: 02
4	Die Category	Drg. No.	M720	
5	Out Side Diameter	Drg. No.	701 H/c	Sd ep OD = 12
6	Inside Diameter	Drg. No.	600.12 H/c	Sid ep length = 17 H/c
7	Width of Pellet Die	Drg. No.	265 H/c	
8	Grooves as per Drawing	Drg. No.	15x8x7 H/c	15x8x7 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: 16 Both Side
12	Tapping PCD		640 H/c	
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/c	Tapping Depth = 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 11/3/25	
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 Row 2 42
2	External Relief Dia	3.5 H/c / 4.0 H/c	3.5 H/c All Rows = 14 H/c	
3	External Relief Depth		4.0 H/c All Rows = 6 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purchase	
6	Material Sent For Hardening On Date		1 3 25	
Inspected By (Sign) & Date			Ravi 11/3/25	

Satyam 13/3/25

Reviewed by (Engineer-CNC)

Manager-QA