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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.		14379	35/40/215
2	Machined By		V.T.L. H/c Shop	By H/c Lark 210
3	Pallet Die No.		13297 (4.0) H/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c Step 002 491 H/c	Step length 12.5
6	Inside Diameter	Drg. No.	420.12 H/c (Bor = 419.8 H/c)	(A)
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 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 Back Side
12	Tapping PCD		454 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 18.3 H/c	Tapping Depth 19.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 1/3/25

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

Count all 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 H/c	outside (2-2)		Inner				
3	External Relief Depth		9 H/c		5 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			1	3	25			

Inspected By (Sign) & Date

Ravi 1/3/25

3/3/25

Reviewed by (Engineer-CNC)

Manager-QA