

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)

9519

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14416 ✓	23/33/66
3	Pallet Die No.		V.T.L. N/A Shop	Drg No. 12.0.320
4	Die Category	Drg. No.	14742 (6.0) N/A	Rev. 08
5	Out Side Diameter	Drg. No.	N. Tumbo	
6	Inside Diameter	Drg. No.	680.1 N/A, Step 00.693 N/A	Tappet 8°
7	Width of Pellet Die	Drg. No.	546.12 N/A (Box = 548.1 N/A)	Step length 31 N/A
8	Grooves as per Drawing	Drg. No.	195 N/A	Under cut = 2.8 N/A
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.1 N/A 32 x 7 x 9.1 N/A (4 x 8) N/A	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		N/A Shop	2 N/A Deep
12	Tapping PCD		619 N/A	Both Side
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	Tapping No
14	Tapping On Second Side	Half pitch of 1st side	ok	of holes 2
15	Tapping Hole Depth		Drill Depth 33.2 N/A	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 3.6
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 2/4/25

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

Counter Sink Row: 12

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	6.5 N/A 7.0 N/A	6.5 N/A	All Rows 2-43 N/A			
3	External Relief Depth		7.0 N/A	All Rows 2-33 N/A			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Purwar			
6	Material Sent For Hardening On Date			2	25		

Inspected By (Sign) & Date

Ravi 2/4/25

Reviewed by (Engineer-CNC)

Manager-QA