

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Inprocess Inspection (Pellet Dies)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

9464

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14531	42/50
2	Machined By		V. T. L. n/c Shop	Dy M. Lark
3	Pallet Die No.		14472 (3.0) n/c	
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	8.20 n/c	Step OD = 611.9 n/c
6	Inside Diameter	Drg. No.	520.12 n/c	Step length = 19.5
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 n/c	13 x 8 x 5 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/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 n/c	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rao: 28/3/25	
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 Sink
2	External Relief Dia	3.3 n/c	Outside 23-32	Inner 8 n/c
3	External Relief Depth		14 n/c	
4	Inspection Done Before Hardening By (Name)		Rao	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		28	3 25
Inspected By (Sign) & Date			Rao: 28/3/25	

Reviewed by (Engineer-CNC)

Manager-QA