

9544

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.		14539	40/50/355
2	Machined By		V.T.C. H/C Shop	Dry H/C Lark 355
3	Pallet Die No.		14474(3.2) H/C	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/C	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H/C of holes 12
12	Tapping PCD		565 H/C	Bottom Side
13	Tapping Hole Diameter		M20 2 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 2 H/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 5/4/25

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 32

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.8 H/C	23-35	Inner	10 H/C		
3	External Relief Depth		16 H/C				
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		5	7	85		

Inspected By (Sign) & Date

Ravi 5/4/25

Set 3 7/6/15

Manager-QA

R Reviewed by (Engineer-CNC)