

9576



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14599 ✓	3045 ✓
2	Machined By		V.T.L. H/c Shop	Dr H. 18.0 579
3	Pallet Die No.		14480 (3.0) H	Renol
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	610 H, Step 00. 315.5 H	Tapper 4°
6	Inside Diameter	Drg. No.	520.14 H	Step length 20mm
7	Width of Pellet Die	Drg. No.	222 H	Under cut 2.75 H
8	Grooves as per Drawing	Drg. No.	13x8x5 H 13x8x5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H	Tapping H of holes 12
13	Tapping Hole Diameter		H20, Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 10/4/25	
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 - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK	Counter 80°	
2	External Relief Dia	3.5 H	Outside (3-3)	Inner
3	External Relief Depth		18 H	15 H
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		10	4 25
Inspected By (Sign) & Date			Sasi 10/4/25	

Reviewed by (Engineer-CNC)

Manager-QA