9733

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.		14814	26/4/2025
2	Machined By		V.T.L M/c Shop	Dy No. Lark 8810
3	Pallet Die No.		13760(4.0) mm	
4	Die Category	Drg. No.	8810	
5	Out Side Diameter	Drg. No.	500 mm, Step OD = 491 mm	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	188 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm / 12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No of Holes = 8 Both Side
12	Tapping PCD		454 mm	
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 18.4 mm	Tapping Depth = 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 26/4/25	
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 = 60°

1	Counter Sinking Depth & Finish	ok						Ravi 25
2	External Relief Dia	4.5 mm	Outside (2=2)		Inner			
3	External Relief Depth		8 mm		4 mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		26	4	25			
	Inspected By (Sign) & Date		Ravi 26/4/25					

Reviewed by (Engineer-CNC) 26/4/25.

Manager-QA