

9869

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.		14876	33/50
2	Machined By		V. T. L. H/c Shop	Dy. Insp. 18.03.13
3	Pallet Die No.		15112 (3.0) H	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9mm Step on 490.9mm	Step length 17.5
6	Inside Diameter	Drg. No.	420.14mm	
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
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 H. L. B. Baku Side
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.8mm Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rev. 15/5/25	
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	3.5mm	Outside 22.2mm	Inner
3	External Relief Depth		23mm	17mm
4	Inspection Done Before Hardening By (Name)		Rev.	
5	Material Sent For Hardening By (Name)		Lark For work	
6	Material Sent For Hardening On Date		15 5 25	
Inspected By (Sign) & Date			Rev. 15/5/25	

Reviewed by (Engineer-CNC)

Manager-QA