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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.		14078	33/50
2	Machined By		V.T.L. H.C. Shop	Dry H.C. 1.8.02.947
3	Pallet Die No.		12127(3.0) H.C.	Rev 2.00
4	Die Category	Drg. No.	H7610	
5	Out Side Diameter	Drg. No.	7mm H.C. Step OD = 692mm	Step length = 18.5
6	Inside Diameter	Drg. No.	600.12mm	
7	Width of Pellet Die	Drg. No.	265mm	
8	Grooves as per Drawing	Drg. No.	15x8x7mm 15x8x7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H.C. Shop	
12	Tapping PCD		640mm	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	Tapping H.C. of Holes = 16 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.2mm Tapping Depth = 18.9mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 19/3/25	
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 = 60	
2	External Relief Dia	3.5mm	Outside 23-35	Inner
3	External Relief Depth		23mm	17mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purchase	
6	Material Sent For Hardening On Date		19	3 25
Inspected By (Sign) & Date			Ravi 19/3/25	

Sats 19/3/25

Reviewed by (Engineer-CNC)

Manager-QA