

8973



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.		13867	4/50
2	Machined By		V. T. L. H/c Shop	Dr. H. 1.8.014805
3	Pallet Die No.		12016 (4.0) H/c	Revised
4	Die Category	Drg. No.	H 120	
5	Out Side Diameter	Drg. No.	701 H/c, Step 00, Tapper 12	
6	Inside Diameter	Drg. No.	600.4 H/c	Step length 12.1 H/c
7	Width of Pellet Die	Drg. No.	265 H/c	
8	Grooves as per Drawing	Drg. No.	15x8x7 H/c 15x8x7 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 16 Rook Side
12	Tapping PCD		640 H/c	
13	Tapping Hole Diameter		H20, Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/c	Tapping Depth 18.5 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 11/1/25

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 65 Rox 39
2	External Relief Dia	4.5 H/c	outside (2-3)	inner				
3	External Relief Depth		14 H/c	10 H/c				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		11	1	25			

Inspected By (Sign) & Date Ravi 11/1/25

Reviewed by (Engineer-CNC) Satish 13/1/25

Manager-QA