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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

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14277	42/50
2	Machined By		V. T. L. n/c Shop	Dr. H. L. D. 276
3	Pallet Die No.		13072 (3.5) n/c	Res. 01
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	620 n/c Step on 623.8 n/c	Tappers 12
6	Inside Diameter	Drg. No.	520.12 n/c	Step length 20 n/c
7	Width of Pellet Die	Drg. No.	186 n/c	Under cut 1.8 n/c
8	Grooves as per Drawing	Drg. No.	13x8x3 n/c 13x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		56.5 n/c	
13	Tapping Hole Diameter		M 2 - Check by H 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 n/c Tapping Depth 18.8 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/7/25

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 Res. 27
2	External Relief Dia	4.0 n/c	outside (3-3)		Inner		
3	External Relief Depth	/	15 n/c		8 n/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		25	2	25		

Inspected By (Sign) & Date

Ravi 25/7/25

Satish 25/7/25

Reviewed by (Engineer-CNC)

Manager-QA