

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9438

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14417	32/39
2	Machined By		V. T. L. H/C Shop	Qty 4.13.02 937
3	Pallet Die No.		13878 (3.2) H/C	Rev 200
4	Die Category	Drg. No.	H7810	
5	Out Side Diameter	Drg. No.	678 H/C Step 602 692 H/C	Step length 20mm
6	Inside Diameter	Drg. No.	600.12 H/C	Under cut 7mm
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 Both 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 18.3 H/C	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 22/3/25	
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	3.8 H/C	All Rows	Rev 35
3	External Relief Depth		7mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porroce	
6	Material Sent For Hardening On Date		22 3 25	
Inspected By (Sign) & Date			Ravi 22/3/25	

Reviewed by (Engineer-CNC)

Manager-QA