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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.		13964 to 14345	55/66
2	Machined By		V. T. L. H/C Shop	(1) Dry No. 12.0-320
3	Pallet Die No.		14017 (8.0) H/C	Rev 208
4	Die Category	Drg. No.	M. 70m bo	
5	Out Side Diameter	Drg. No.	680.1 H/C Step 00, 693 H/C	Tapper - 8
6	Inside Diameter	Drg. No.	546.12 H/C (Bore 548.1 H/C)	Step length 31.2 H/C
7	Width of Pellet Die	Drg. No.	195 H/C	Under cut - 2.8 H/C
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/C / 32 x 7 x 9.1 H/C (4 x 8) H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Pure side Step]
10	Drilling Area Surface Smoothness		OK	[2nd Deck Both Side]
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 H/C	[Tapping H/C of holes 2 Both Side]
13	Tapping Hole Diameter		H/C, Check by H/C Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.2 H/C	Tapping Depth 3.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rao: 20/3/25	
1	As per programme no.		Final Fitting	
2	Gun Drilling Work Completed On		Size Dry	
3	Hole Finish In Gun Drilling	Marked	OK	Not 12.0-320
4	Defective Holes (If Any)		No	Rev 203
Note : Mark the defective holes/Missed holes with the help of Permanent Marker			Counter 30	
1	Counter Sinking Depth & Finish	OK		Rev 20
2	External Relief Dia	9.0 H/C	All Rows	
3	External Relief Depth		11 H/C	
4	Inspection Done Before Hardening By (Name)		Rao	
5	Material Sent For Hardening By (Name)		Lark Ramesh	
6	Material Sent For Hardening On Date		20	3 25
Inspected By (Sign) & Date			Rao: 20/3/25	

Reviewed by (Engineer-CNC)

Manager-QA