

9518

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.		14416	23/33/66
2	Machined By		V.T.L. H/c Shop	Dr. No. 12.02.32
3	Pallet Die No.		14741 (6.0) H/c	Rev. 08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	380.1 H/c Step 001 693 H/c	Tapber. 8
6	Inside Diameter	Drg. No.	546.12 H/c (Bore 548.1) H/c	Step length 31 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	Face Side 34
10	Drilling Area Surface Smoothness		OK	2 H/c Depth
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 H/c	Tapping No. of Holes. 2
13	Tapping Hole Diameter		H16. Check by H16 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 33.2 H/c Tapping Depth. 31.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/4/25

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

Counter Bore

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 H/c 7.0 H/c	6.5 H/c	All Rows 243 H/c					
3	External Relief Depth		7.0 H/c	All Rows 33 H/c					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Purvace					
6	Material Sent For Hardening On Date			2	4	25			

Inspected By (Sign) & Date

Ravi 21/4/25

Reviewed by (Engineer-CNC)

Manager-QA