

9453

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.		14446	32/50
2	Machined By		V. T. C. n/c Shop	Dr H. 12.2 19
3	Pallet Die No.		14119 (24.0) n/c	Rev 2.0
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c Shop ON 692 n/c	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 n/c 12.5 x 8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping H. of Holes 12 Both Side
12	Tapping PCD		645 n/c	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22.2 n/c	Tapping Depth 20.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24/3/25

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 - 1 Hole Colused

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 2 Go

1	Counter Sinking Depth & Finish	ok								Rev 2.32
2	External Relief Dia	4.5 n/c	Outside 83.3		Inner					
3	External Relief Depth		22 n/c		18 n/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		24	3	25					
Inspected By (Sign) & Date										

Ravi 24/3/25

Reviewed by (Engineer-CNC)

Manager-QA