

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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14405	30/40/66
3	Pallet Die No.		V.T.L. n/c Shop	33/43/66
4	Die Category	Drg. No.	14739(6.0) n/c	Drg No. 12.0.009
5	Out Side Diameter	Drg. No.	N. 7.0 n/c	Rev. 03
6	Inside Diameter	Drg. No.	680.7 n/c	Step 00. 699 n/c
7	Width of Pellet Die	Drg. No.	546.12 n/c (Box 548.4 n/c)	Tapper 8
8	Grooves as per Drawing	Drg. No.	195 n/c	6d n/c
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.2 n/c 32.7 x 9.2 n/c (4.2) n/c	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		ok	8 n/c
12	Tapping PCD		n/c Shop	Side
13	Tapping Hole Diameter		819 n/c	Tapping n/c
14	Tapping On Second Side	Half pitch of 1st side	NIG 2 Check by NIG B. 1	of hole
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.2 n/c	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		yes	
			ok	
Inspected By (Sign) & Date			Ravi 22/8/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		N.	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok	1st Pad	2nd Pad
2	External Relief Dia	6.5 n/c 7.0 n/c	6.5 n/c 36 n/c	6.5 n/c 33 n/c
3	External Relief Depth		7.0 n/c 26 n/c	7.0 n/c 23 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purnace	
6	Material Sent For Hardening On Date		22	3 25
Inspected By (Sign) & Date			Ravi	

Reviewed by (Engineer-CNC)

Manager-QA