

9552

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.		14475	41/51
2	Machined By		V. T. L. H/c Shop	Dr. H. 1.2.2013 295
3	Pallet Die No.		13915 (4.5) H/c	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	382 H/c Step 002	Tapper 12°
6	Inside Diameter	Drg. No.	580.12 H/c	Step length 32 H/c
7	Width of Pellet Die	Drg. No.	266 H/c	
8	Grooves as per Drawing	Drg. No.	28.5 x 6 x 12 H/c	28.5 x 6 x 12 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
12	Tapping PCD		230 H/c	of holes 12
13	Tapping Hole Diameter		H/c Check by H/c Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 25.2 H/c	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 5/4/25	
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				
1	Counter Sinking Depth & Finish	OK		Counter 60° Row 2 38
2	External Relief Dia	5.0 H/c	Outside (3-3)	Inner
3	External Relief Depth		15 H/c	10 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		5 4 25	
Inspected By (Sign) & Date			Ravi 5/4/25	

Satyam
5/4/25

Reviewed by (Engineer-CNC)

Manager-QA