

9488

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.		14472	93/77
2	Machined By		V. T. B. n/c Shop	Qty No. 12.0.1042
3	Pallet Die No.		14039(6.0) n/c	Rev 2.00
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1004 n/c Step 00.1022.8 n/c	Tapper 8°
6	Inside Diameter	Drg. No.	848.12 n/c / 850.1 n/c (Bor. 850.4)	Step length 45 n/c
7	Width of Pellet Die	Drg. No.	266	Under cut 23.9 n/c
8	Grooves as per Drawing	Drg. No.	45x6x11 n/c / 45x6x10 n/c	(12x10) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 n/c Reeb Boh
11	Tapping Operator		n/c Shop	Side
12	Tapping PCD		929 n/c	Tapping Holes
13	Tapping Hole Diameter		M20. Check by M20 Ball	g holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 35.2 n/c	Tapping Depth 33.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 31/3/25	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter 30°
2	External Relief Dia	7.5 n/c	All Rows	Row 18
3	External Relief Depth		54 n/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		31 3 25	
Inspected By (Sign) & Date			Ravi 31/3/25	

Reviewed by (Engineer-CNC)

Manager-QA