

955's

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.		14517	53/58
2	Machined By		V.T.L. n/a Shop	Drg. No. 12.0.810
3	Pallet Die No.		11543 (3.8) n/a	Rev. no
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	746 n/a Step on: 743 n/a	Tabber 4°
6	Inside Diameter	Drg. No.	630.12 n/a	Step length 27.5
7	Width of Pellet Die	Drg. No.	255 n/a	
8	Grooves as per Drawing	Drg. No.	22x8x7 n/a / 22x8x7 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	Tapping Ho of holes 12
12	Tapping PCD		685 n/a	Both Side
13	Tapping Hole Diameter		M22, Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 28.3 n/a	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Soni 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 - 2 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter Sink Row 36
2	External Relief Dia	4.3 n/a	Outside 2.3-3.5	Inner 5 n/a
3	External Relief Depth		12 n/a	
4	Inspection Done Before Hardening By (Name)		Soni	
5	Material Sent For Hardening By (Name)		Lark Purwar	
6	Material Sent For Hardening On Date		25 4 25	
Inspected By (Sign) & Date			Soni 5/4/25	

Reviewed by (Engineer-CNC)

Manager-QA