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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.			
2	Machined By		14665	38/50
3	Pallet Die No.		V.T.L. n/c Shop	Drg H. 1.2.0.125-1
4	Die Category	Drg. No.	14409 (4.0) n/c	Rev. 01
5	Out Side Diameter	Drg. No.	H. 7.0 n/c	
6	Inside Diameter	Drg. No.	700 n/c Step 00- 698 n/c	Tabber = 12°
7	Width of Pellet Die	Drg. No.	600.12 n/c	Step length = 2 n/c
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12-8 x 7 n/c 12-8 x 7 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		840 n/c	
13	Tapping Hole Diameter		M2 - Check by M2 Bolt	Tabbing H. of Holes = 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 n/c Tapping Depth = 18.5 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sai: 15/4/25	
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 = 8.0
2	External Relief Dia	4.5 n/c	Outside (3-3)	Inner
3	External Relief Depth		16 n/c	12 n/c
4	Inspection Done Before Hardening By (Name)		Sai!	
5	Material Sent For Hardening By (Name)		Lark Porpace	
6	Material Sent For Hardening On Date		15	4 25
Inspected By (Sign) & Date			Sai: 15/4/25	

Reviewed by (Engineer-CNC)

Manager-QA