

9644

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 (Pollet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14687 ✓	413/50 ✓
3	Pallet Die No.		V.T.L. n/c Shop	Dy 2 L2C-9980
4	Die Category	Drg. No.	14819 (4.0) n/c	Rev 1.00 ✓
5	Out Side Diameter	Drg. No.	2nd saw side	
6	Inside Diameter	Drg. No.	6.20 n/c, Step 002 Tapping 12°	
7	Width of Pellet Die	Drg. No.	5.20.1.2 n/c	Step length 18.5
8	Grooves as per Drawing	Drg. No.	2.2.2 n/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		56.5 n/c ✓	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	[Tapping Holes of Holes 12 Bed Side]
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 8.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/4/25

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

Count 2260
Rev 2.31

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 n/c	Outside (3-3)		Inner		
3	External Relief Depth		11 n/c		7 n/c		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		17	4	25		

Inspected By (Sign) & Date

Ravi 17/4/25

Reviewed by (Engineer-CNC)

Manager-QA