

9664

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.		14777	34/50/ 8355
2	Machined By		V. T. L. H/O Shop	(Dy. M. Lark)
3	Pallet Die No.		14625 (4.0) mm	
4	Die Category	Drg. No.	2-drawside	
5	Out Side Diameter	Drg. No.	62 mm, Step 002 61.9 mm	Step length 7.5
6	Inside Diameter	Drg. No.	52.0 mm	
7	Width of Pellet Die	Drg. No.	22.2 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		56.5 mm	
13	Tapping Hole Diameter		M20: Check by H2-Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sav: 19/4/25	
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
2	External Relief Dia	4.5 mm	Outside (3-3)	Rows 31
3	External Relief Depth		20 mm	16 mm
4	Inspection Done Before Hardening By (Name)		Sav:	
5	Material Sent For Hardening By (Name)		Lark Purrace	
6	Material Sent For Hardening On Date		19	4
Inspected By (Sign) & Date			Sav: 19/4/25	

Reviewed by (Engineer-CNC)

Manager-QA