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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.		14606	3047
2	Machined By		V.T.L. H/O Shop	Dy. H. 12.2.565
3	Pallet Die No.		14406 (3.0) H/H	Rev: 00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	693.8 H/H Step 02: 692.8 H/H	Tapping 12
6	Inside Diameter	Drg. No.	600.12 H/H	Step length 20mm
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/H / 12x8x7 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping H/O of Holes 12
12	Tapping PCD		640 H/H	Both Side
13	Tapping Hole Diameter		H/O Shop Check by wire Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/H	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 28/4/25	
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 - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter Bore 239
2	External Relief Dia	3.5 H/H	Outside (3-3)	Inner
3	External Relief Depth		20 H/H	17 H/H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Parnore	
6	Material Sent For Hardening On Date		28	4
Inspected By (Sign) & Date			Ravi 28/4/25	

Reviewed by (Engineer-CNC)

Manager-QA