

9739

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.		14810	39/51
2	Machined By		V.T.L. H/a Shop	Dy. No. 12.0, 880
3	Pallet Die No.		12383(3.0) H/a	Rev. No.
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	801.8 H/a	
6	Inside Diameter	Drg. No.	700.12 H/a	
7	Width of Pellet Die	Drg. No.	320 H/a	
8	Grooves as per Drawing	Drg. No.	25x10x9 H/a 25x10x9 H/a	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/a Shop	Tapping H/a of H/a 12
12	Tapping PCD		750 H/a	Both Side
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 35.4 H/a Tapping Depth 33.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter 80°
2	External Relief Dia	3.8 H/a	Outside (3-3)	11mm
3	External Relief Depth		18 H/a	12 H/a
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Permore	
6	Material Sent For Hardening On Date		28 4 25	
Inspected By (Sign) & Date			Sasi 28/4/25	

Sasi 28/4/25

Reviewed by (Engineer-CNC)

Manager-QA