

9868

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14860	28/38/66
2	Machined By		N.T.L. H/C Shop	Dry H. 12.0. G. 9
3	Pallet Die No.		15015 (B.O.) H. 12.0. G. 9	Rev 203
4	Die Category	Drg. No.	H. 12.0. G. 9	
5	Out Side Diameter	Drg. No.	G 8.7 H. 12.0. G. 9	Tap hole 8
6	Inside Diameter	Drg. No.	54.6.12 H. 12.0. G. 9	Step length 31
7	Width of Pellet Die	Drg. No.	195 H. 12.0. G. 9	Galvanic 2.5
8	Grooves as per Drawing	Drg. No.	32.7.9.2 H. 12.0. G. 9	(4.0) H. 12.0. G. 9
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side 8
10	Drilling Area Surface Smoothness		OK	2 H. 12.0. G. 9
11	Tapping Operator		H/C Shop	Both Side
12	Tapping PCD		619 H. 12.0. G. 9	Tapping 2
13	Tapping Hole Diameter		HIG Check by HIG Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 H. 12.0. G. 9	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 15/5/25

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

Counter 30

1	Counter Sinking Depth & Finish	OK							Row 12
2	External Relief Dia	6.5 H. 12.0. G. 9	6.5 H. 12.0. G. 9	All Rows 28					
3	External Relief Depth		4.0 H. 12.0. G. 9	All Rows 28					
4	Inspection Done Before Hardening By (Name)			Row 1					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date		15	5	25				

Inspected By (Sign) & Date

Ravi 15/5/25

Manager-QA

Reviewed by (Engineer-CNC)