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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.		15036	40/60
2	Machined By		V.T.L. H/C Shop	By H. L. O. 584
3	Pallet Die No.		14543 (G.O) H/C	Revised
4	Die Category	Drg. No.	Jump	
5	Out Side Diameter	Drg. No.	780 H/C Step 002	798 H/C Tapped
6	Inside Diameter	Drg. No.	660.12 H/C	Step length 28.5
7	Width of Pellet Die	Drg. No.	324 H/C	Undercut 9 H/C
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H/C of H.L.O. 12
12	Tapping PCD		725 H/C	Both Side
13	Tapping Hole Diameter		H20. Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 30.4 H/C	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 22/5/25	2 Slot
1	As per programme no.			32.1 H/C H20
2	Gun Drilling Work Completed On			8 H/C Deep
3	Hole Finish In Gun Drilling	Marked	OK	Both Side
4	Defective Holes (If Any)		N.	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter Sink
2	External Relief Dia	6.5 H/C	Outside 23-25	Inner 20 H/C
3	External Relief Depth		26 H/C	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Remace	
6	Material Sent For Hardening On Date		27 5 25	
Inspected By (Sign) & Date			Ravi 22/5/25	

Reviewed by (Engineer-CNC)

Manager-QA