

10022

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.			
2	Machined By		15077	35/69
3	Pallet Die No.		V.T.I. n/c Shop	Day 4-18.0.893
4	Die Category	Drg. No.	14800(G.O) n/c	Rev. 00
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	838 n/c Step 002 847.8 n/c Topper. 50	
7	Width of Pellet Die	Drg. No.	698.12 n/c (Bar. 700.14 n/c)	Step length. 38.5
8	Grooves as per Drawing	Drg. No.	240 n/c	Order cut = 1.89 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	29x10x9 n/c / 29x10x9 n/c	(Gx7) n/c
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		n/c Shop	1 n/c Dao P
12	Tapping PCD		765 n/c	Both Side
13	Tapping Hole Diameter		M16: Check by M16 Bolt	Tapping H.
14	Tapping On Second Side	Half pitch of 1st side	ok	of holes 2
15	Tapping Hole Depth		Drill Depth. 32.4 n/c	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 30.6
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sai: 5/6/25	
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 30
2	External Relief Dia	1.0 n/c	All Rows	Row 218
3	External Relief Depth		34 n/c	
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		5 6 25	
Inspected By (Sign) & Date			Sai: 5/6/25	

Sai: 5/6/25

Reviewed by (Engineer-CNC)

Manager-QA