

10/21



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.		15167	50/50
2	Machined By		V. T. L. M/C Shop	By H. D. 2450
3	Pallet Die No.		15450 (G.O) M/C	Rev. 01
4	Die Category	Drg. No.	J & W	
5	Out Side Diameter	Drg. No.	730 M/C	Step on. 748.4 M/C
6	Inside Diameter	Drg. No.	630.14 M/C	Step length 2.5 M/C
7	Width of Pellet Die	Drg. No.	290 M/C	Under cut. 6.7 M/C
8	Grooves as per Drawing	Drg. No.	15x8x5 M/C	Face Side Step
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Back Side
10	Drilling Area Surface Smoothness		OK	Both Side
11	Tapping Operator		M/C Shop	Tapping 4.7
12	Tapping PCD		685 M/C	of Hole 1.6
13	Tapping Hole Diameter		420. Check by 42 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 20.4 M/C	Tapping Depth. 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 18/6/25	Face groove Day
1	As per programme no.			No. - 12.0 2450
2	Gun Drilling Work Completed On			Rev. 01
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 60
2	External Relief Dia	6.5 M/C	Outside (3.3)	Inside
3	External Relief Depth		3 M/C	Drill
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furace	
6	Material Sent For Hardening On Date		18 6 25	
Inspected By (Sign) & Date			Ravi 18/6/25	

Reviewed by (Engineer-CNC)

Manager-QA