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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 (Pollet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15298	42/CC
2	Machined By		V. T. C. H/c Shop	Dy H. 13.0.78
3	Pallet Die No.		15334(6.0)H	Renzo
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	678 H	Step 00, 693 H, Tapken
6	Inside Diameter	Drg. No.	546.12 H (Bor = 548.4) H	Step length 38
7	Width of Pellet Die	Drg. No.	195 H	Under cut = 2.8 H
8	Grooves as per Drawing	Drg. No.	31x8x9 H / 31x8x9 H	(5x8) H
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	Inner Drill
11	Tapping Operator		H/c Shop	Back Side
12	Tapping PCD		619 H	Tapping H
13	Tapping Hole Diameter		H16. Check by H16 B.12	of Luler. 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Back Side
15	Tapping Hole Depth		Drill Depth. 38.4 H	Tapping Depth. 36
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 30/6/25	
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 3
2	External Relief Dia	7.0 H	All Rows	Rep: 12
3	External Relief Depth		24 H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark R. V. R. R. R.	
6	Material Sent For Hardening On Date		30 6 25	
Inspected By (Sign) & Date			Ravi 30/6/25	

Reviewed by (Engineer-CNC)

Manager-QA