

10230



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.		15403	35/66
2	Machined By		V. T. L. H/O Shop	Dy. No. 18.2.32
3	Pallet Die No.		15338 (R.O) H/O	Rev. 08
4	Die Category	Drg. No.	H. Tumbler Gun	
5	Out Side Diameter	Drg. No.	680.1 mm, Step on 693 mm	Tabber. 8
6	Inside Diameter	Drg. No.	546.14 mm (Box. 548.2)	Step length. 3
7	Width of Pellet Die	Drg. No.	195 mm	Order cut. 2.8
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 mm 32 x 7 x 9.1 mm (4 x 8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side 2
10	Drilling Area Surface Smoothness		OK	2 mm Deep
11	Tapping Operator		H/O Shop	Bottom Side
12	Tapping PCD		319 mm	Tapping H
13	Tapping Hole Diameter		HIG. Check by HIG B.O.T	of Loke. 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Bottom Side
15	Tapping Hole Depth		Drill Depth. 33.4 mm	Tapping Dept. 3.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 8/7/25	
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	9.0 mm	All Rows	Rev. 10
3	External Relief Depth		31 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Parnace	
6	Material Sent For Hardening On Date		8 7 25	
Inspected By (Sign) & Date			Ravi 8/7/25	

Reviewed by (Engineer-CNC)

Manager-QA