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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15275	34/50
3	Pallet Die No.		V.7.L n/c Stop	Qty n/c 18.0.119
4	Die Category	Drg. No.	14422(2.8) n/c	Rev. 00
5	Out Side Diameter	Drg. No.	M-Jumbo	
6	Inside Diameter	Drg. No.	7mm Step OD 891.9 n/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	600.14 n/c	
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12.5 x 8 x 7 n/c / 12.5 x 8 x 7 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Stop	
13	Tapping Hole Diameter		645 n/c	Tapping n/c of holes 12
14	Tapping On Second Side	Half pitch of 1st side	M2 x 2 Check by M2 Bolt	Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 22.4 n/c	Tapping Depth 20.5
17	Visual Inspection Before Gun Drilling		yes	
			ok	
Inspected By (Sign) & Date			Ravi 14/7/25	
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 60
2	External Relief Dia	3.3mm	Outside 23.3	Bar 40
3	External Relief Depth		22mm	Inner 16mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		14 7 25	
Inspected By (Sign) & Date			Ravi 14/7/25	

Reviewed by (Engineer-CNC)

Manager-QA