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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 (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15464	58/66
2	Machined By		V. T. L. H/C Shop	Dy 4.12.03
3	Pallet Die No.		15505 (9.0) H/C	Rev. 08
4	Die Category	Drg. No.	H. T. M. H/C	
5	Out Side Diameter	Drg. No.	680.1 H/C	Tap hole - 8°
6	Inside Diameter	Drg. No.	546.12 H/C (Bor = 548.2)	Step length 31mm
7	Width of Pellet Die	Drg. No.	195 H/C	Under cut = 2.8mm
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H/C	(4 x 8) H/C
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side Step
10	Drilling Area Surface Smoothness		OK	2mm Paap
11	Tapping Operator		H/C Shop	Both Side
12	Tapping PCD		619 H/C	Tapping H/C
13	Tapping Hole Diameter		H/C Check by H/C Bolt	of Hole 2.2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.6 H/C	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 23/7/25	
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. Go
2	External Relief Dia	10.0 H/C	All Rows	Rev. 8
3	External Relief Depth		8 H/C	
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		23 7 25	
Inspected By (Sign) & Date			Sasi 23/7/25	

Reviewed by (Engineer-CNC)

Manager-QA