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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.		15079	48/66
2	Machined By		V. T. L. H/C Shop	Dry H. 12.0.830
3	Pallet Die No.		15162 (B.O) H	Rev 208
4	Die Category	Drg. No.	M. Tumbler	✓
5	Out Side Diameter	Drg. No.	680.1 H 3 step 0.2 693 H Tapper 8	
6	Inside Diameter	Drg. No.	546.14 H (Bor 548.2 H) Step length = 31 H	
7	Width of Pellet Die	Drg. No.	195 H	Lead cut = 2.3 H
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H 32.7 x 9.1 H (408) H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 H Deep
11	Tapping Operator		H/C Shop	Both Side
12	Tapping PCD		619 H	Tapping H
13	Tapping Hole Diameter		H16 Check by H16 Ball	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth = 33.4 H Tapping Depth = 31.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 21/7/25	
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 B
2	External Relief Dia	9.0 H	All Rows	Row 10
3	External Relief Depth		18 H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		21 7 25	
Inspected By (Sign) & Date			Ravi 21/7/25	

Reviewed by (Engineer-CNC)

Manager-QA