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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.			
2	Machined By		15925 ✓	36/50 ✓
3	Pallet Die No.		V.T.L. w/c Shop	Dr. No. 12.02450
4	Die Category	Drg. No.	15785 (4.0) ✓	Revised
5	Out Side Diameter	Drg. No.	742	
6	Inside Diameter	Drg. No.	730.44 ✓	Step 0.0 742.94 ✓
7	Width of Pellet Die	Drg. No.	630.144 ✓	Tapper 10°
8	Grooves as per Drawing	Drg. No.	290.644 ✓	Step length 28.3
9	Fitting Sizes on CNC Plate	Drg. No.	15.3x8x544 ✓	6 den cut 744
10	Drilling Area Surface Smoothness		OK	Face Side
11	Tapping Operator		w/c Shop	Step 0.844
12	Tapping PCD		684.944 ✓	Deep Bottom Side
13	Tapping Hole Diameter		42.2 ✓	Tapping H
14	Tapping On Second Side	Half pitch of 1st side	OK	of Hole 216
15	Tapping Hole Depth		Drill Depth 20.544 ✓	Bottom Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 18.5 ✓
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 19/9/25	
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	4.544 ✓	Outside (3-3)	Low 43
3	External Relief Depth		1844 ✓	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Rurnace	
6	Material Sent For Hardening On Date		19 9 25	
Inspected By (Sign) & Date			Ravi 19/9/25	

Reviewed by (Engineer-CNC)

Manager-QA