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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.		14687	43/50
2	Machined By		V. T. L. H/c. Shop	Dr. H. 13.0.085
3	Pallet Die No.		14722 (4.0) H/c.	Rev. 2.00
4	Die Category	Drg. No.	SSS-10	
5	Out Side Diameter	Drg. No.	620.14 H/c. Step 002 824 H/c. Tapper 12	
6	Inside Diameter	Drg. No.	520.14 H/c.	Step length 20 H/c.
7	Width of Pellet Die	Drg. No.	186 H/c.	120 H/c. 2 H/c.
8	Grooves as per Drawing	Drg. No.	13-8-3 H/c. / 13-8-3 H/c.	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c. Shop	
12	Tapping PCD		565 H/c.	
13	Tapping Hole Diameter		H20-2 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20 H/c. Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rao: 16/4/25	
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 - Hole Reused	
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	4.5 H/c.	Outside 23-35	Rev. 2.5
3	External Relief Depth		11 H/c.	Inner 7 H/c.
4	Inspection Done Before Hardening By (Name)		Rao	
5	Material Sent For Hardening By (Name)		Lark Ropack	
6	Material Sent For Hardening On Date		16 4 25	
Inspected By (Sign) & Date			Rao: 16/4/25	

Reviewed by (Engineer-CNC)

Manager-QA