

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9486

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.		14658	32/50
2	Machined By		V.T.L. m/c Shop	Depth 1.6 mm
3	Pallet Die No.		13881(4.0) mm	Rec 2.02
4	Die Category	Drg. No.	J4 D	
5	Out Side Diameter	Drg. No.	701 mm Step on Tappet 12°	
6	Inside Diameter	Drg. No.	800.12 mm	Step length 17 mm
7	Width of Pellet Die	Drg. No.	265 mm	
8	Grooves as per Drawing	Drg. No.	15 x 8 mm / 15 x 8 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		m/c Shop	Tapping m/c
12	Tapping PCD		640 mm	of holes 2.18
13	Tapping Hole Diameter		M20, Check by M20 Drill	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Soni 31/3/25	
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 Sink
2	External Relief Dia	4.5 mm	Outside 23-33	Inner
3	External Relief Depth		20 mm	18 mm
4	Inspection Done Before Hardening By (Name)		Soni	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		31 3 25	
Inspected By (Sign) & Date			Soni 31/3/25	

Reviewed by (Engineer-CNC)

Manager-QA