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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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14522	30/6/6
2	Machined By		UTC - m/c shop	Drg No. 320 Rev 01
3	Pallet Die No.		14768 (6.0 mm)	
4	Die Category	Drg. No.	m. Jumbo	Tapper 8
5	Out Side Diameter	Drg. No.	680.1mm Step on 293	Step Length 31
6	Inside Diameter	Drg. No.	548.1mm (Box - 548.1)	under cut 2.8mm
7	Width of Pellet Die	Drg. No.	195 mm	
8	Grooves as per Drawing	Drg. No.	32x7x9.1 32x4x9.1 (C)	Tapping No of
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Hole - 2 both side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		m/c shop	
12	Tapping PCD		619mm	[Rare side Step]
13	Tapping Hole Diameter		m/c - Check by HIG	[2 mm Deep]
14	Tapping On Second Side	Half pitch of 1st side	OK	Both side
15	Tapping Hole Depth		drill depth - 33.5	Tapping Depth - 81.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

mahesh 04/04/25

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

Counter 80

1	Counter Sinking Depth & Finish	OK						Row - 29
2	External Relief Dia	7.0mm	outer		Inner			
3	External Relief Depth		36 mm		36 mm			
4	Inspection Done Before Hardening By (Name)		mahesh					
5	Material Sent For Hardening By (Name)		Lark furnace					
6	Material Sent For Hardening On Date		04	04	25			

Inspected By (Sign) & Date

mahesh 04/04/25

Reviewed by (Engineer-CNC)

Manager-QA