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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.		14353 ✓	40/52
2	Machined By		UTL M/c Shop	Draw No 549 (Rev)
3	Pallet Die No.		14135 (4.0 mm)	
4	Die Category	Drg. No.	m-Jumbo	Step length 20
5	Out Side Diameter	Drg. No.	704 mm, Step 02 - 693-4	
6	Inside Diameter	Drg. No.	585 mm	Taper 12
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 / 12x10x7.5	Tapping 70 of
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Male - 12
10	Drilling Area Surface Smoothness		2/2	Both Side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		640 mm	
13	Tapping Hole Diameter		m 20 Checking by m 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 Tapping Depth 18.5	
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				
1	Counter Sinking Depth & Finish	OK		Counter for
2	External Relief Dia	4.5mm	out side (2-3)	inner
3	External Relief Depth		16mm	12mm
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