

9556

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14567	40/40
2	Machined By		V. T. L. n/c Shop	Dy. M. 18.07.13
3	Pallet Die No.		14327 (4.0) mm	Ren 200
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	391 mm, Step 00. 389 mm	Step length 9.5
6	Inside Diameter	Drg. No.	310.12 mm / 311.12 mm	
7	Width of Pellet Die	Drg. No.	146 mm	
8	Grooves as per Drawing	Drg. No.	15 x 8 x 3 mm / 15 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		356 mm	
13	Tapping Hole Diameter		11/2" - Check by 11/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	11/2" - Check by 11/2" Bolt	
15	Tapping Hole Depth		Drill Depth 18.2 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sai: 5/4/25	
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	
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 2.25	Inner
3	External Relief Depth		4 mm	Mill
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark Romace	
6	Material Sent For Hardening On Date		5	4
Inspected By (Sign) & Date			Sai: 5/4/25	

Reviewed by (Engineer-CNC)

Manager-QA