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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.		14630 ✓	33/66
2	Machined By		V.T.L. H/c Shop	Dy H., 1-8-0-9
3	Pallet Die No.		14811 (G.O.) H/c	Rev: 03
4	Die Category	Drg. No.	M. Joubo	
5	Out Side Diameter	Drg. No.	680.7 H/c Step 00: 693 H/c	Tabber 8"
6	Inside Diameter	Drg. No.	546.12 H/c (Bot: 548.4 H/c)	Step length: 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut: 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 H/c 32.7 x 9.2 H/c (4 x 8) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 H/c Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		819 H/c	Tapping Ho
13	Tapping Hole Diameter		H16.2 Check by H16 Ball	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth: 33.4 H/c	Tapping Dept: 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 15/4/25	
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 30"
2	External Relief Dia	7.5 H/c	All Rows	Row: 12
3	External Relief Depth		33 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		15 4 25	
Inspected By (Sign) & Date			Ravi 15/4/25	

Reviewed by (Engineer-CNC)

Manager-QA