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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. N/A Shop	Drilled 18.0.60
3	Pallet Die No.		14809 (G-0) N/A	Rev. 03
4	Die Category	Drg. No.	N. T. L. N/A	
5	Out Side Diameter	Drg. No.	680.7 mm Step 002 693 mm	Tapping 87
6	Inside Diameter	Drg. No.	546.12 mm (Bore 548.4 mm)	Step length 9.9 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut - 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm / 32 x 7 x 9.2 mm (4 x 8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face side Step 2 mm Deep Bore
11	Tapping Operator		N/A Shop	Side
12	Tapping PCD		619 mm	Tapping Holes of holes 2
13	Tapping Hole Diameter		N/A Check by M16 Bolt	Both Sides
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.4 mm Tapping Depth 33.6 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sai 16/4/25	
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	1.5 mm	All Rows	Row 12
3	External Relief Depth		33 mm	
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark Parnace	
6	Material Sent For Hardening On Date		16 4 25	
Inspected By (Sign) & Date			Sai 16/4/25	

Reviewed by (Engineer-CNC)

Manager-QA