

9645

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.		14683 ✓	30/45 ✓
2	Machined By		V.T.L. N/C Shop	Drill No. 6201287
3	Pallet Die No.		14118 (3.0) mm	Rev. 00
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	610mm Step 00 = 623mm	Tapper 12°
6	Inside Diameter	Drg. No.	520.12mm	Step length 2mm
7	Width of Pellet Die	Drg. No.	190mm	End center 6.5mm
8	Grooves as per Drawing	Drg. No.	17.5 x 5 x 3mm / 17.5 x 5 x 9mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No. of holes 12
12	Tapping PCD		565mm	Both Side
13	Tapping Hole Diameter		M18 Check by M18 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 24.4mm Tapping Depth 22.7mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 10/4/25	
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 20
2	External Relief Dia	3.5mm	50 Side (3-3)	Inner
3	External Relief Depth		18mm	15mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Parnoor	
6	Material Sent For Hardening On Date		17	4
Inspected By (Sign) & Date			Ravi 17/4/25	

Reviewed by (Engineer-CNC)

Manager-QA