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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.		14631 ✓	19/66
2	Machined By		V. T. L. N/A Shop	Dr. H. 12.02.09
3	Pallet Die No.		14819 (0.0) N/A	Rev. 03
4	Die Category	Drg. No.	N. Tumbo	
5	Out Side Diameter	Drg. No.	680.7 mm Step 00, 692 mm	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 mm (Bot. 548.4 mm)	Step length 31 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	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 mm Deep
11	Tapping Operator		N/A Shop	Both Side
12	Tapping PCD		619 mm	Tapping H.
13	Tapping Hole Diameter		N/A - Check by N/A Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.3 mm	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 18/4/25	
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 80
2	External Relief Dia	7.5 mm	All Rows	Row 12
3	External Relief Depth		47 mm	
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Purvace	
6	Material Sent For Hardening On Date		18 4 25	
Inspected By (Sign) & Date			Sasi 18/4/25	

Reviewed by (Engineer-CNC)

Manager-QA