

9658



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.		14640	33/47
2	Machined By		V.T.L. N/A Shop	Dr. H. L. S. 996
3	Pallet Die No.		14408 (C.3.0) N/A	Rev = 00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	694 N/A - Step 00 = 693 N/A	Tapper = 4°
6	Inside Diameter	Drg. No.	600.12 N/A	Step length = 21 N/A
7	Width of Pellet Die	Drg. No.	222 N/A	
8	Grooves as per Drawing	Drg. No.	14x8x7 N/A 14x8x7 N/A	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	
12	Tapping PCD		640 N/A	
13	Tapping Hole Diameter		N 202 Check by N 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 22.3 N/A	Tapping Depth = 20.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Res: 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

Counter = 60°

1	Counter Sinking Depth & Finish	OK								Res: 38
2	External Relief Dia	3.5 N/A	Outside (2-3)		Inner					
3	External Relief Depth		20 N/A		14 N/A					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		18	4	25					

Inspected By (Sign) & Date

Res: 18/4/25

Reviewed By (Engineer-CNC)

Manager-QA