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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.		14589	35/50/65
2	Machined By		V.T.L. n/c Shop	Dr. H. 18.0.69
3	Pallet Die No.		14775 (6.0) n/c	Revised
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	6.80.7 n/c Step 06. 69.3 n/c	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 n/c Box 548.4 n/c	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 n/c 32.7 x 9.2 n/c (4 x 8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step
10	Drilling Area Surface Smoothness		ok	2 n/c Deck
11	Tapping Operator		n/c Shop	Both Side
12	Tapping PCD		619 n/c	Tapping No.
13	Tapping Hole Diameter		M16. Check by M16 Bole	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.3 n/c	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi 24/4/25	
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 n/c	
2	External Relief Dia	6.5 n/c 1.0 n/c	6.5 n/c All Rows 31 n/c	
3	External Relief Depth	1.0 n/c	1.0 n/c All Rows 16 n/c	
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Purnace	
6	Material Sent For Hardening On Date		20 4 25	
Inspected By (Sign) & Date			Sasi 24/4/25	

Reviewed by (Engineer-CNC)

Manager-QA