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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.		14751 ✓	36/50
2	Machined By		V.T.L. H/c Shop	Dr H. 12.25 309
3	Pallet Die No.		12847 (4.0) ✓	Rev. 00
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	620mm Step 00. 622.4mm Tapper 123	
6	Inside Diameter	Drg. No.	520.12mm	Step length 20.1mm
7	Width of Pellet Die	Drg. No.	190mm	Locker width 1.2mm
8	Grooves as per Drawing	Drg. No.	15x5x3mm / 15x5x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		565mm	of holes 12
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 25.4mm Tapping Depth 29.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rao: 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 25
2	External Relief Dia	4.5mm	outside (3-3)	inner
3	External Relief Depth		18mm	14mm
4	Inspection Done Before Hardening By (Name)		Rao	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		24 4 25	
Inspected By (Sign) & Date			Rao: 24/4/25	

Reviewed by (Engineer-CNC)

Manager-QA