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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.		15189	4.5/60
2	Machined By		V.T.L. H/c Shop	Drilled 12.2-13.13
3	Pallet Die No.		15944 (B.O) H/c	Revised
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/c	Tapping H/c
6	Inside Diameter	Drg. No.	660.14 H/c	Step length = 85.5
7	Width of Pellet Die	Drg. No.	384 H/c	Undercut = 9 H/c
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 7 H/c	
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		725 H/c	of holes = 12
13	Tapping Hole Diameter		M20, Check by M20 Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 22.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 16/7/25	2 Slot
1	As per programme no.			32.1 H/c hole
2	Gun Drilling Work Completed On			8 H/c Back
3	Hole Finish In Gun Drilling	Marked	OK	Back Side
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 Sink
2	External Relief Dia	8.5 H/c	20.8 Side	Inner
3	External Relief Depth		23 H/c	15 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		16	7 25
Inspected By (Sign) & Date			Ravi 16/7/25	

Reviewed by (Engineer-CNC)

Manager-QA