

10664



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.		15964 ✓	53/58 ✓
2	Machined By		V. T. L. H/c Shop	Dy. H. 1.2.0.398
3	Pallet Die No.		15357(3.8) H/c	Rev. 1.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	776 H/c	Step 00.800 H/c, Side length 98 H/c
6	Inside Diameter	Drg. No.	660.14 H/c	Undercut 12 H/c
7	Width of Pellet Die	Drg. No.	316 H/c	
8	Grooves as per Drawing	Drg. No.	20 x 8 x 7.5 H/c / 20 x 8 x 7.5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		725 H/c	
13	Tapping Hole Diameter		720 - Check by H2-Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 25.4 H/c	Tapping Depth 23.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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 Sink
2	External Relief Dia	4.3 H/c	Outside (2.3-3)		Inner					Rev. 47
3	External Relief Depth		12 H/c		5 H/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		16	9	25					

Inspected By (Sign) & Date

Satou
16/9/25

Manager-QA