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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.		15956 to 16066	55/55
2	Machined By		V. T. L. H/c Shop	Drg No. 18.0.453
3	Pallet Die No.		15465 (4.0) mm	Revised
4	Die Category	Drg. No.	J & W	2
5	Out Side Diameter	Drg. No.	740 mm Step 00.743.4 mm	
6	Inside Diameter	Drg. No.	630.14 mm	Tabber, 10°
7	Width of Pellet Die	Drg. No.	290 mm	Step length 8 mm
8	Grooves as per Drawing	Drg. No.	15x8x5 mm / 15x8x5 mm	Under cut 1.75
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side
10	Drilling Area Surface Smoothness		OK	Step 0.8 mm
11	Tapping Operator		H/c Shop	Deep Bottom Side
12	Tapping PCD		685 mm	Tabbing No. of Hole 16
13	Tapping Hole Diameter		H202 Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 19/9/25	Final Ritting
1	As per programme no.			Size Dia
2	Gun Drilling Work Completed On			N. 18.0.453
3	Hole Finish In Gun Drilling	Marked	OK	Revised
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 B.
2	External Relief Dia	4.5 mm	Outside (3-3)	Revised
3	External Relief Depth		8 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		19/9/25	
Inspected By (Sign) & Date			Ravi 19/9/25	

Reviewed by (Engineer-CNC)

Manager-QA