

9528

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14565	52/52
2	Machined By		MTL. m/c shop	any No - 233 (Rev 01)
3	Pallet Die No.		14721	Rev 01
4	Die Category	Drg. No.	35570	Step length 19.5
5	Out Side Diameter	Drg. No.	624 mm Step on 2134	Both side
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	186 mm	Tapping roof
8	Grooves as per Drawing	Drg. No.	13x8x3 / 13x8x3	Hole - 12
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Both side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		m/c shop	
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		m/c Checking by m/c Belt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 10.3 Tapping depth 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

mahesh 04/04/25

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

Counter 60

1	Counter Sinking Depth & Finish	OK						Row 28
2	External Relief Dia	4.5mm	outside (3-3)		Inner			
3	External Relief Depth		5mm					
4	Inspection Done Before Hardening By (Name)		mahesh					
5	Material Sent For Hardening By (Name)		Lark furnace					
6	Material Sent For Hardening On Date		04	04	25			

Inspected By (Sign) & Date

mahesh 04/04/25

Reviewed by (Engineer-CNC)

Manager-QA