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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.		14743	40/50
2	Machined By		V. T. L. N/C Shop	Depth 18.0 415
3	Pallet Die No.		15026 (4.0)	Revol
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52mm Step 002 499mm	Step length 20mm
6	Inside Diameter	Drg. No.	42.12mm	Tappet 12°
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping of holes 8
12	Tapping PCD		454mm	Both Side
13	Tapping Hole Diameter		420, Check by 420 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.3mm	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 19/6/25	
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 60
2	External Relief Dia	4.5mm	Outside 2.25	Inner
3	External Relief Depth		14mm	10mm
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		19	25
Inspected By (Sign) & Date			Sasi 19/6/25	

Reviewed by (Engineer-CNC)

Manager-QA