9/03

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.		13201	53/100
2	Machined By		V.T.L M/c Shop	Drg No. L.E.C.9743
3	Pallet Die No.		13935 (8.0) mm	Rev. 03
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1051 mm, Step 00. 1041.84 mm	
6	Inside Diameter	Drg. No.	851.4 mm C.I.D Step Tapper 15°)	Tapper. 4°
7	Width of Pellet Die	Drg. No.	251 mm	Step length 39.5
8	Grooves as per Drawing	Drg. No.	50x11x10.3 mm / 50x11x10.3	mm C.I.D. Step length
9	Fitting Sizes on CNC Plate	Drg. No.	OK	17mm/15mm
10	Drilling Area Surface Smoothness		OK	will be maintain
11	Tapping Operator		m/c Shop	in final size M/c
12	Tapping PCD		958 mm	Tapping no
13	Tapping Hole Diameter		M.30 check by M.30 Bolt	of Holes. 24
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 43.6mm	Tapping Depth 42mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi	
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. 30° Rev. 12
2	External Relief Dia	9.0 mm	ALL	Rows				
3	External Relief Depth			45 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		27	1	25			
	Inspected By (Sign) & Date		Ravi 27/01/25					

Reviewed by (Engineer-CNC) 27/1/25

Manager-QA

Scanned with CamScanner