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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.		14028 ✓	140/55 ✓
2	Machined By		V.T.L n/c Shop	Dy No. 1-20-14951
3	Pallet Die No.		13586(8.0) ✓	Per 200 ✓
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	689.8 mm ✓	Step on 621.5 mm, Tapped 12
6	Inside Diameter	Drg. No.	520.1 mm ✓	Step Per 519.9 mm, Step length 2.5
7	Width of Pellet Die	Drg. No.	222 mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	[Tapping No of Holes = 12 Back Side]
12	Tapping PCD		565 mm ✓	
13	Tapping Hole Diameter		M202 Check by M20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.3 mm	Tapping Depth 8.6 mm ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/1/25

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
Part 18

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	8.5 mm ✓	Outside (3-3)	Inner			
3	External Relief Depth		2.3 mm ✓	1.5 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		28	1	25		

Inspected By (Sign) & Date

Ravi 28/1/25

28/1/25

Reviewed by (Engineer-CNC)

Manager-QA