9145

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.		13986	35/40/66
2	Machined By		V.T.L M/c Shop	Drg No. LSD-609
3	Pallet Die No.		14011 (6.0) MM	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 MM, Step OD = 693 MM	Tapper = 8'
6	Inside Diameter	Drg. No.	546.12 MM (Bore = 548.8 MM)	Step length = 31 MM
7	Width of Pellet Die	Drg. No.	195 MM	Under cut = 2.5 MM
8	Grooves as per Drawing	Drg. No.	32x7x9.2 MM / 32x7x9.2 MM (4x7.6 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 MM Deep Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No of Holes 2 Both Side
12	Tapping PCD		619 MM	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.3 MM	Tapping Depth = 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 4/2/25	
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 = 30° Row = 12
2	External Relief Dia	6.5 MM / 7.0 MM	6.5 MM All Rows = 31 MM					
3	External Relief Depth		7.0 MM All Rows = 26 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		4	2	25			
	Inspected By (Sign) & Date		Ravi 4/2/25					

Satyr 5/2/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner