9179

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	55/100
2	Machined By		V.T.L. N/C Shop	Dy No. L.E.C.9143 Rev 03
3	Pallet Die No.		13936(8.0) HH	
4	Die Category	Drg. No.	3. Jumbo	
5	Out Side Diameter	Drg. No.	1051.1 HH / Step OD = 1041.3 HH Tapper 4°	
6	Inside Diameter	Drg. No.	B51.4 HH (BD Tapper = 15°) Step length 38.5 HH	
7	Width of Pellet Die	Drg. No.	251 HH	
8	Grooves as per Drawing	Drg. No.	50×11×10.3 HH / 50×11×10.3 HH (ID Step length 17 HH Tapper 15°	
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 24 Both Side
12	Tapping PCD		958 HH	
13	Tapping Hole Diameter		M30 HH Check by M30 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 48.6 HH Tapping Depth. 41.4	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 7/8/25	
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° Rev. 12
2	External Relief Dia	9.0 HH	All Rows						
3	External Relief Depth			45 HH					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		7	8	25				
	Inspected By (Sign) & Date		Ravi 7/8/25						

Reviewed by (Engineer-CNC) 7/8/25

Manager-QA

Scanned with CamScanner