9188

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.		14184 /	40/48/55 /
2	Machined By		V.T.L H/C Shop	Drg No. 15.026 GC
3	Pallet Die No.		14107 (A.0) HH /	Rev 00 /
4	Die Category	Drg. No.	H. Turbo	
5	Out Side Diameter	Drg. No.	709.8 HH / Step OD 692.3 HH Tapper 12°	
6	Inside Diameter	Drg. No.	Bore 12 HH /	Step length 20 HH
7	Width of Pellet Die	Drg. No.	222.1 HH /	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 HH / 12x10x7.5 HH /	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		H/C Shop	Tapping No of Hole 12 Both Side
12	Tapping PCD		640 HH /	
13	Tapping Hole Diameter		M20 Crack by M20 Bolt /	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 20.3 HH Tapping Depth 18.6 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 13/2/25	
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 90° / Rows 22
2	External Relief Dia	6.5HH / 7.0HH	6.5HH	All Rows	2	15 HH /			
3	External Relief Depth		7.0HH	All Rows	2	7 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		13	2	25				
	Inspected By (Sign) & Date		Ravi 13/2/25						

Satish 13/2/25
Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner