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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.		14084	33/66
2	Machined By		V.T.C. N/C Shop	Dyn. (3.0.30)
3	Pallet Die No.		14020 (B.O) H	Row 08
4	Die Category	Dr. No.	M. Jumbo	
5	Out Side Diameter	Dr. No.	680.1 mm Step OD 692.8 mm	Tapper 8°
6	Inside Diameter	Dr. No.	546.12 mm (Bor: 548.12 mm)	Step length: 31 mm
7	Width of Pellet Die	Dr. No.	195 mm	Undercut: 2.8 mm
8	Grooves as per Drawing	Dr. No.	32 x 7 x 9.1 mm 32 x 7 x 9.1 mm	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	[Race Side Step 2 mm Deep Bolt Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	[Tapping No of Holes: 2 Bolt 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: 31.7 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 15/2/25

1	As per programme no.			Final size
2	Gun Drilling Work Completed On			As per Drg.
3	Hole Finish In Gun Drilling	Marked	ok	LSD-609
4	Defective Holes (If Any)		No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter: 30

1	Counter Sinking Depth & Finish	ok							Row: 12
2	External Relief Dia	7.5 mm	All Rows						
3	External Relief Depth		33 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		15	8	25				

Inspected By (Sign) & Date Ravi 15/2/25

Reviewed by (Engineer-CNC) S. J. S. 15/2/25

Manager-QA