

9277



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.		14164 ✓	55/100 ✓
2	Machined By		V.T.L. H/c Shop	Dy. No. 1.2.2.9743
3	Pallet Die No.		14268 (8.0) H/c ✓	Rev 03 ✓
4	Die Category	Drg. No.	3. Jumbo	
5	Out Side Diameter	Drg. No.	1051 H/c, Step 00 = 1041.8 H/c	Tappes 4°
6	Inside Diameter	Drg. No.	851.2 H/c C10 Tappes 15°	Step length 325
7	Width of Pellet Die	Drg. No.	251 H/c	
8	Grooves as per Drawing	Drg. No.	50x11x10.2 H/c 50x11x10.2 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes 24 Both Side
12	Tapping PCD		958 H/c ✓	
13	Tapping Hole Diameter		M302 Check by M30 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 43.7 H/c	Tapping Depth 41 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 26/7/25

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

Counters 30°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	9.0 H/c	All Rows							
3	External Relief Depth		45 H/c							
4	Inspection Done Before Hardening By (Name)		Ravi							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		26	2	25					

Inspected By (Sign) & Date

Ravi 26/7/25

Reviewed by (Engineer-CNC)

Manager-QA