9449

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.		12478	24/24
2	Machined By		V.T.L M/c Shop	Dy No. 1.8.24
3	Pallet Die No.		13287 (1.0) MM	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	698 MM, Step OD = 794 MM	Tapper. 12°
6	Inside Diameter	Drg. No.	650.12 MM	Step length. 33 MM
7	Width of Pellet Die	Drg. No.	245 MM	Under cut = 48 MM
8	Grooves as per Drawing	Drg. No.	27x8x12 MM / 27x8x12 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Tapping No of Holes = 8 Both side
12	Tapping PCD		720 MM	
13	Tapping Hole Diameter		M24 = Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 30.2 MM	Tapping Depth. 28.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi 24/3/25	
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 — 100 Hole Coloured	

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

Counter = 60°

1	Counter Sinking Depth & Finish	Not-OK						Ravi
2	External Relief Dia	Discussed with Sachin Sir	—	No - Relief				
3	External Relief Depth		—	—	—			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		24	3	25			
	Inspected By (Sign) & Date		Ravi 24/3/25					

Satya 24/3/25
Reviewed by (Engineer-CNC)

Manager-QA