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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.		14198	33/10
2	Machined By		V. T. C. N/C Shop	By No. 12.0.1263
3	Pallet Die No.		14212 (400) mm	Row 200
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	398 mm / Step OD: 383 mm	Step length: 0.5
6	Inside Diameter	Drg. No.	318.12 mm	
7	Width of Pellet Die	Drg. No.	108 mm	
8	Grooves as per Drawing	Drg. No.	7.5 x 5 x 3 mm / 7.5 x 5 x 3 mm	
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: 8 Both Side
12	Tapping PCD		350 mm	
13	Tapping Hole Diameter		ok	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 12.3 mm	Tapping Depth: 10.8 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raj: 10/3/25

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

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

1	Counter Sinking Depth & Finish	ok						Counter = 60°
2	External Relief Dia	4.5 mm	outside (2.25)	Inner				Row 2-14
3	External Relief Depth		12 mm	8 mm				
4	Inspection Done Before Hardening By (Name)							Raj
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		10	3	25			

Inspected By (Sign) & Date

Raj: 10/3/25

Saty: 10/3/25

Reviewed by (Engineer-CNC)

Manager-QA