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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.		14321	48/66
2	Machined By		V. T. L. N/O Shop	50/66
3	Pallet Die No.		14501 (8.0)mm	Drg No. 13.0.230
4	Die Category	Drg. No.	M. Tumbo	Res 208
5	Out Side Diameter	Drg. No.	680.1mm / 81.4mm OD, 693mm	Tapper 8°
6	Inside Diameter	Drg. No.	546.12mm (Bore = 548.1mm)	Step length 31.2mm
7	Width of Pellet Die	Drg. No.	195mm	Under cut 2.8mm
8	Grooves as per Drawing	Drg. No.	32x7x9.1mm 32x7x9.1mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Face side Step 2nd Deep Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/O	
12	Tapping PCD		619mm	[Tapping No of holes 2 Both Side]
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2mm	Tapping Depth 31.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 12/3/25	
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 = 30 Raws = 12
2	External Relief Dia	9.0mm	1st Rad All Rows = 18mm	
3	External Relief Depth		2nd Rad All Rows = 16mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		12 / 3 / 25	
Inspected By (Sign) & Date			Ravi 12/3/25	

Reviewed by (Engineer-CNC)
Sats 12/3/25

Manager-QA