9358

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.		14354	4465
2	Machined By		V.T.L H/C Shop	Dy No. 1.3.2788
3	Pallet Die No.		14736 (6.0) HH	Rev 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	678 HH, Step OD: 693 HH	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 HH (PG 548.3 HH)	Step length 38 HH
7	Width of Pellet Die	Drg. No.	195 HH	Under cut 3.2 HH
8	Grooves as per Drawing	Drg. No.	31x8x9.1 HH / 31x8x9.1 HH (5x8) HH	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 1HH Dep to Body Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 HH	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Tapping Ho of Holes d Body Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 38.2 HH	Tapping Depth 36.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 11/3/25	
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

Counter = 30°

1	Counter Sinking Depth & Finish	ok							Ravi 12
2	External Relief Dia	7.0 HH	All Rods						
3	External Relief Depth			24 HH					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		11	3	25				
	Inspected By (Sign) & Date		Ravi 11/3/25						

Satish 11/3/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner