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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.		14382	35/60/90
2	Machined By		V.T.L. n/c Shop	Py H. 18.0.859
3	Pallet Die No.		13640(6.0) n/c	Rev. 02
4	Die Category	Drg. No.	N760	
5	Out Side Diameter	Drg. No.	75.2 mm, Step 002 77.7 mm / 77.8 mm / 67.5 mm	
6	Inside Diameter	Drg. No.	57.2.12 mm	Step length. 42 mm
7	Width of Pellet Die	Drg. No.	270 mm	84.5 mm
8	Grooves as per Drawing	Drg. No.	106 x 8 x 12 mm / 88 x 8 x 12 mm	Under cut = 12.5 mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Tapping H. of Holes]
12	Tapping PCD		660 mm	
13	Tapping Hole Diameter		only 2 Check by 0.5 mm Ball	
14	Tapping On Second Side	Half pitch of 1st side	one Side Tapping and 1nd Side One Slot	
15	Tapping Hole Depth		Drill Depth 35.2 mm Tapping Depth 33.5 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 21/8/25	[1 Slot]
1	As per programme no.			39.1 mm width
2	Gun Drilling Work Completed On			28 mm Deep
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		Count on 6. Row 27
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm All Rows 2 55 mm	
3	External Relief Depth		7.0 mm All Rows 2 30 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ramesh	
6	Material Sent For Hardening On Date		21 3 25	
Inspected By (Sign) & Date			Ravi 21/8/25	

Reviewed by (Engineer-CNC)

Manager-QA