9506

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.		14569	35/40
2	Machined By		V.T.L. H/C Shop	Drg No. L.E.C.150C2
3	Pallet Die No.		14669 (3.2) mm	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm, Step OD = 498.8 mm	Tapper H.
6	Inside Diameter	Drg. No.	480.12 mm	Step length 18.5
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm / 12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	[Tapping H. of holes 8 Both Side]
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 mm	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 2/4/25	
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 Sink Rev. 03
2	External Relief Dia	3.8 mm	Outside 62.29		Inner			
3	External Relief Depth		11 mm		5 mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		2	4	25			
	Inspected By (Sign) & Date		Ravi 2/4/25					

Reviewed by (Engineer-CNC) 2/4/25

Manager-QA