

9579

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.			45/45
2	Machined By		14341	
3	Pallet Die No.		V.T.L H/c Shop	
4	Die Category	Drg. No.	14435 (5.0)	
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	445.4 mm, Step 00	438.4 mm / 436.4 mm
7	Width of Pellet Die	Drg. No.	355.6 mm	Step length 8.5 mm
8	Grooves as per Drawing	Drg. No.	199.8 mm	Tapper 15°
9	Fitting Sizes on CNC Plate	Drg. No.	46 x 5 x 6 mm 13.5 x 4 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		394 mm	
14	Tapping On Second Side	Half pitch of 1st side	M16, Check by M16 Bolt	
15	Tapping Hole Depth		one side Tapping and 2nd side Tapping	
16	Perpendicularity of Tapped Hole		Drill Depth 38.4 mm	Tapping Depth 38 mm
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 5/4/25

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

Count as 60

1	Counter Sinking Depth & Finish	ok	outside	As Per Sketch	
2	External Relief Dia	5.5 mm	one line	2nd line	3rd line
3	External Relief Depth		10 mm	8 mm	6 mm
4	Inspection Done Before Hardening By (Name)				
5	Material Sent For Hardening By (Name)				
6	Material Sent For Hardening On Date		5	7	25

Inspected By (Sign) & Date

Ravi 5/4/25

Reviewed by (Engineer-CNC)

Manager-QA