

9625

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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14631	19/06
2	Machined By		V.T.L. n/c Shop	18.0.06-9
3	Pallet Die No.		14818(6.0) n/c	Ren:03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm Step 0.8 mm	Tabba 8°
6	Inside Diameter	Drg. No.	546.12 mm (Box = 548.4 mm)	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 mm / 32.7 x 9.2 mm (4 x 3) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep Bottom
11	Tapping Operator		n/c Shop	Side
12	Tapping PCD		619 mm	Tapping n/c
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	of hole 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 mm	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/07/25

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
Row 12

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	7.5 mm		All Rows			
3	External Relief Depth			42 mm			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Romare			
6	Material Sent For Hardening On Date		15	4	25		

Inspected By (Sign) & Date

Ravi 15/07/25

Reviewed by (Engineer-CNC)
Set 15/07/25

Manager-QA