9700

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.		14806	40/50
2	Machined By		V.T.L. M/C Shop	Dy No. L.S.D.405
3	Pallet Die No.		15109(3.5)mm	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520mm, Step OD. 499mm	Tapper. 12
6	Inside Diameter	Drg. No.	420.12mm	Step length. 17mm
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		454mm	Tapping Holes of Holes 8 Both Side
13	Tapping Hole Diameter		08/4" Chale by 08/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 18.4	Tapping Depth. 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 23/4/25	
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

Counter Go

1	Counter Sinking Depth & Finish	ok						Ravi 22
2	External Relief Dia	4.0mm	outside (2.2)		Inner			
3	External Relief Depth		17mm		10mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		23	4	25			
	Inspected By (Sign) & Date		Ravi 23/4/25					

Satish 23/4/25.

Reviewed by (Engineer-CNC)

Manager-QA