9782

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.		14772	5d/SS
2	Machined By		V.T.L H/c Shop	Dy No. L80-6-9
3	Pallet Die No.		14982 (8.0) mm	Rev 03
4	Die Category	Drg. No.	N. Turbo	
5	Out Side Diameter	Drg. No.	680.7 mm, Step OD: 693 mm	Taper = 8°
6	Inside Diameter	Drg. No.	546.12 mm (Box = 548.4 mm)	Step length 3 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut: 2.5 mm
8	Grooves as per Drawing	Drg. No.	38 x 7 x 9.2 mm / 32 x 7 x 9.2 mm (4 x 8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep Both Side
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 mm	Tapping No of holes 2 Both Side
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 38.4 mm	Tapping Depth: 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 3/5/25	
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 = 30° Rev = 10
2	External Relief Dia	9.0 mm	All holes					
3	External Relief Depth			16 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		3	5	25			
	Inspected By (Sign) & Date		Ravi 3/5/25					

3/5/25

Reviewed by (Engineer-CNC)

Manager-QA