9866

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoulli 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.		14860	28/38/66
2	Machined By		V.T.L. M/c Shop	Dy No. L.S.D.G-9
3	Pallet Die No.		14994 (6.0) mm	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	2473
5	Out Side Diameter	Drg. No.	680.7 mm, Step OD 693 mm	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 mm (Bore 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.	3d x 7 x 9.2 mm / 3d x 7 x 9.2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep
11	Tapping Operator		M/c. Shop	Both Side
12	Tapping PCD		619 mm	Tapping No
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	of Holes 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 14/5/25	
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						Counters 30 Rows 12
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm All Rows = 38 mm					
3	External Relief Depth		7.0 mm All Rows = 28 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		14	5	25			
	Inspected By (Sign) & Date		Ravi 14/5/25					

Satya 14/5/25.

Reviewed by (Engineer-CNC)

Manager-QA