9871

Lark Engineering Company (India) Pvt. Ltd.	Form No.	CNC/QA/FM/02
I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)	Rev. No.	01
Inprocess Inspection (Pellet Dies)	Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14903	30/50
2	Machined By		V.T.L H/C Shop	Drg No. 18.0.578
3	Pallet Die No.		1.4802 (3.0) mm	Rev. 01
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 mm, Step OD: 615.4 mm	Taper = 4°
6	Inside Diameter	Drg. No.	520.14 mm	Step length 20 mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13×8×5 mm / 13×8×5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of Holes 12 Both Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 15/5/25	
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 90° Rev: 38
2	External Relief Dia	3.3 mm	Out Side (3.3)		Inner			
3	External Relief Depth		23 mm		20 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		15	5	25			
	Inspected By (Sign) & Date		Ravi 15/5/25					

Satya 15/5/25.

Reviewed by (Engineer-CNC)

Manager-QA