

9884

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.			
2	Machined By		14996 ✓	GG/AG
3	Pallet Die No.		V.7.L. n/c Shop	Dry Holes 18.2.30
4	Die Category	Drg. No.	15154 (12.0) n/c	Rev. 08
5	Out Side Diameter	Drg. No.	N. Jumbo	
6	Inside Diameter	Drg. No.	680.1mm Step 00, 693.4mm	Tappers 8°
7	Width of Pellet Die	Drg. No.	546.12 mm (Box, 548.14mm)	Side length 23mm
8	Grooves as per Drawing	Drg. No.	195mm	Under cut = 2.8mm
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.1 mm / 32.7 x 9.1mm (4x8)mm	Face Side Step
10	Drilling Area Surface Smoothness		ok	9mm Deep
11	Tapping Operator		n/c Shop	Both Side
12	Tapping PCD		619mm	Tapping Holes
13	Tapping Hole Diameter		NIS, Check by NIS Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.4mm	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 16/5/25	
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 Sink
2	External Relief Dia			Ravi 16
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Perreace	
6	Material Sent For Hardening On Date		16 5 25	
Inspected By (Sign) & Date			Ravi 16/5/25	

Sites
16/5/25

Reviewed by (Engineer-CNC)

Manager-QA