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
Inprocess Inspection (Pellet Dies)	Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13069	32/70
2	Machined By		V.T.L M/c Shop	30/70
3	Pallet Die No.		10746 (6.0) MM	Drg No. 1.89.077 Rev 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 MM, Step OD 697.8 MM	Tapper 5°
6	Inside Diameter	Drg. No.	548.12 MM	Step length 38.5 MM
7	Width of Pellet Die	Drg. No.	215 MM	39 MM
8	Grooves as per Drawing	Drg. No.	29.5x10x8 MM / 29.5x10x8 MM	Undercut = 1.8 MM (6x8) MM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Step MM Deep Both Side
11	Tapping Operator		M/c Shop	Tapping No. of Holes 2 Both Side
12	Tapping PCD		618 MM	
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 32.8 MM	Tapping Depth 30.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 16/10/24	
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 = 30°

1	Counter Sinking Depth & Finish	ok						Rev = 14
2	External Relief Dia	7.0 MM	Ist Pad		IInd Pad			
3	External Relief Depth		38 MM		40 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		16	10	24			
	Inspected By (Sign) & Date		Ravi 16/10/24					

Satya 16/10/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner