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.		13674	38/66
2	Machined By		V.T.L M/C Shop	40/66
3	Pallet Die No.		13349(8.0) MM	Drg No. LSD 21095
4	Die Category	Drg. No.	M. Jumbo	Rev = 00
5	Out Side Diameter	Drg. No.	680 MM, Step OD = 692.5 MM	Tapper = 5°
6	Inside Diameter	Drg. No.	546.12 MM (Bar = 548.12 MM)	Step length = 38 MM
7	Width of Pellet Die	Drg. No.	215 MM	Undercut = 3.15 MM
8	Grooves as per Drawing	Drg. No.	30.5 x 6 x 9.1 MM | 30.5 x 6 x 9.1 MM	(6 x 8) MM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side
10	Drilling Area Surface Smoothness		ok	Step 1 MM
11	Tapping Operator		M/C Shop	Deep Both Side
12	Tapping PCD		620 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 = 32.2 MM Tapping Depth = 30.5 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 2/1/25	
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

Counter = 30°

1	Counter Sinking Depth & Finish	ok						Row = 12
2	External Relief Dia	9.0 MM	Ist Pad		IInd Pad			
3	External Relief Depth		28 MM		26 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		2	1	25			
	Inspected By (Sign) & Date		Ravi 2/1/25					

Satya 2/1/25.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner