7861

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.		14860	28/38/86
2	Machined By		V.T.L M/c Shop	Drg No. 18.9.69
3	Pallet Die No.		14993 (6.0) mm	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm, Step OD 693 mm	Tapper 2°
6	Inside Diameter	Drg. No.	546.12 mm (Bor. 548.4 mm)	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Lower cut 2.5 mm
8	Grooves as per Drawing	Drg. No.	32×7×9.2 mm / 32×7×9.2 mm	(4×8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side
10	Drilling Area Surface Smoothness		ok	Step 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 mm	Tapping Depth = 31.7 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 13/5/25	
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 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 = 38 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		13	5	25			
	Inspected By (Sign) & Date		Ravi 13/5/25					

Satya 13/5/25.

Reviewed by (Engineer-CNC)

Manager-QA