9946

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.		14924	50/66
2	Machined By		V.T.L m/c Shop	Dy No. 18.0 Rev 08
3	Pallet Die No.		15145 (8.0) mm	
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	880.1 mm Step OD: 693 mm, Tapper 8°	
6	Inside Diameter	Drg. No.	548.14 mm (Bor. 548.8 mm)	Step length. 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut. 2.8 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 mm | 32 x 7 x 9.1 mm	(4 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step
10	Drilling Area Surface Smoothness		ok	2 mm Deep Both
11	Tapping Operator		M/c Shop	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. 33.4 mm Tapping Depth - 31.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rai: 23/5/25	
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

Counter. 90° Rows 12

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	9.0 mm	All	Rows				
3	External Relief Depth			18 mm				
4	Inspection Done Before Hardening By (Name)		Rai:					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		23	5	25			
	Inspected By (Sign) & Date		Rai: 23/5/25					

23/5/25.

Reviewed by (Engineer-CNC)

Manager-QA