10028

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.		15050	44/50
2	Machined By		V.T.L m/c Shop	Dy No. 18.D.450
3	Pallet Die No.		15224(4.0) mm	Rev=00
4	Die Category	Drg. No.	JGD	
5	Out Side Diameter	Drg. No.	790mm Step OD: 743.4mm	Tapper: 10°
6	Inside Diameter	Drg. No.	630.14mm	Step length ~ 23mm
7	Width of Pellet Die	Drg. No.	290 mm	Under Cut: 6.7mm
8	Grooves as per Drawing	Drg. No.	15x8x5mm / 15x8x5mm	Face Side Step 0.8mm Deep Both Side
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		m/c. Shop	Tapping No of Holes = 16 Both Side
12	Tapping PCD		685mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm Tapping Depth 18.5mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 6/6/25	
1	As per programme no.		—	Face Groove Dy No. 18.D=450 Rev=01
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: 60°

1	Counter Sinking Depth & Finish	ok						Rev: 43
2	External Relief Dia	4.5mm	Outside 3.3		Inner			
3	External Relief Depth		14mm		6mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		6	6	25			
	Inspected By (Sign) & Date		Ravi 6/6/25					

Satish 6/6/25.

Reviewed by (Engineer-CNC)

Manager-QA