9977

| | | | |
|---|---|---|---|
| **Lark Engineering Company (India) Pvt. Ltd.**<br>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. | | 15089 | 50/66 |
| 2 | Machined By | | V.T.L. M/C Shop | 55/66 |
| 3 | Pallet Die No. | | 15151 (10.0) mm | Drg No. 18.0.809 |
| 4 | Die Category | Drg. No. | M-Jumbo | Rev. 03 |
| 5 | Out Side Diameter | Drg. No. | 680.7 mm, Step OD = 693 mm | Tapper 8° |
| 6 | Inside Diameter | Drg. No. | 546.14 mm (Box = 548.4 mm) | Step length. 31 mm |
| 7 | Width of Pellet Die | Drg. No. | 195 mm | Under Cut = 2.5 mm |
| 8 | Grooves as per Drawing | Drg. No. | 32×7×9.2 mm / 32×7×9.2 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. 33.4 mm | Tapping Depth. 31.5 |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |
| | **Inspected By (Sign) & Date** | | Ravi 28/5/25 | |
| 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. 60°

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | Rev. 8 |
| 2 | External Relief Dia | 11.0 mm | [Ist Pad | | [IInd Pad | | | |
| 3 | External Relief Depth | | 16 mm] | | | 11 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 | | 28 | 5 | 25 | | | |
| | **Inspected By (Sign) & Date** | | Ravi 28/5/25 | | | | | |

28/5/25

Reviewed by (Engineer-CNC)

Manager-QA