10017

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.		15065	40/45/55
2	Machined By		V.T.L. M/C Shop	Dy No. 1.8.0.1030
3	Pallet Die No.		1427 (R.O) MM	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710 MM, Step OD. 692 MM	Step length = 19.5
6	Inside Diameter	Drg. No.	600.12 MM	
7	Width of Pellet Die	Drg. No.	222 MM	
8	Grooves as per Drawing	Drg. No.	36x10x7 MM / 36x10x7 MM	
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. 12 Both Side
12	Tapping PCD		645 MM	
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 = 20.5 MM	Tapping Depth. 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 3/6/25	
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. 60° Rows. 13
2	External Relief Dia	8.5MM/9.0 MM	8.5MM	All Rows = 15MM				
3	External Relief Depth		9.0MM	All Rows = 10MM				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		3	6	25			
	Inspected By (Sign) & Date		Ravi 3/6/25					

Satya 3/6/25.

Reviewed by (Engineer-CNC)

Manager-QA