10039

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
Inprocess Inspection (Pellet Dies)		Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15185	48/66
2	Machined By		V.T.L M/C Shop	Drg No. 1.8.0.980
3	Pallet Die No.		15910 (8.0) mm	Rev. 08
4	Die Category	Drg. No.	M. Tombo	
5	Out Side Diameter	Drg. No.	680.1 mm, Step OD Groove 693 mm	Tappers 8°
6	Inside Diameter	Drg. No.	546.12 mm (Box. 548.2 mm)	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Undercut 2.8 mm
8	Grooves as per Drawing	Drg. No.	32×7×9.1 mm / 32×7×9.1 mm (4×8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step
10	Drilling Area Surface Smoothness		ok	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 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 7/6/25	
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

Counter. 30° Ro 102 10

1	Counter Sinking Depth & Finish	Ok						
2	External Relief Dia	9.0 mm	All Holes					
3	External Relief Depth	✓		18 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		7	6	25			
	Inspected By (Sign) & Date		Ravi 7/6/25					

Satish 7/6/25.

Reviewed by (Engineer-CNC) Manager-QA