10075

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.		15169	38150
2	Machined By		V.T.I M/C Shop	Drg No. 1820.388 Rev 00
3	Pallet Die No.		15121 (4.0) mm	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm, Step OD: 500 mm	Tapper: 10°
6	Inside Diameter	Drg. No.	420.12 mm	Step length: 18 mm
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm / 12 x 8 x 3 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: 8 Both Side]
12	Tapping PCD		455 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: 18.6 mm	Tapping Depth: 16.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 13/6/25	
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: 60
Rev: 20

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.5 mm	Outside (2-2)		Inner			
3	External Relief Depth		16 mm		12 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		13	6	25			
	Inspected By (Sign) & Date		Ravi 13/6/25					

Satbo 13/6/25

Reviewed by (Engineer-CNC) Manager-QA