10187

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.		15343	34/44/66
2	Machined By		V.T.L. N/C Shop	Drg. No. 18.0-609
3	Pallet Die No.		15150 (8.0) mm	Rev. 03
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm, Step OD 692.8 mm	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 mm (Box, 548.4 mm)	Step length - 3 mm
7	Width of Pellet Die	Drg. No.	195 mm	Undercuts 2.5 mm
8	Grooves as per Drawing	Drg. No.	32×7×9.2 mm / 32×7×9.2 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		N/C Shop	Both Side
12	Tapping PCD		619 mm	Tapping No.
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	of Holes 8
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 1/7/25	
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 Bo

1	Counter Sinking Depth & Finish	ok						Row. 10
2	External Relief Dia	8.5 mm / 9.0 mm	8.5 mm	All Rows 2 3 7 mm				
3	External Relief Depth		9.0 mm	All Rows 2 3 7 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		1	7	25			
	Inspected By (Sign) & Date		Ravi 1/7/25					

1/7/25

Reviewed by (Engineer-CNC)

Manager-QA