10268

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		15184	40/50/70
2	Machined By		V.T.L M/C Shop	Drg No. LD. 377
3	Pallet Die No.		14340 (8.0) mm	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 mm, Step OD. 697.7 mm	Tapper 5°
6	Inside Diameter	Drg. No.	546.14 mm (Bore = 548.3)	Step length 38.5
7	Width of Pellet Die	Drg. No.	215 mm	Under cut 1.8 mm
8	Grooves as per Drawing	Drg. No.	29.5×10×9.1 mm / 29.5×10×9.1 mm (6×8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	Face Side Step 1 mm Deep
10	Drilling Area Surface Smoothness		Ok	Both Side
11	Tapping Operator		M/C Shop	
12	Tapping PCD		618 mm	Tapping no. of holes 2 Both Side
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 32.4 mm	Tapping Depth 30.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 11/7/25	
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 30°
Rad. 12

1	Counter Sinking Depth & Finish	Ok						
2	External Relief Dia	8.5 mm / 90°	8.5 mm	All Holes 2 30 mm				
3	External Relief Depth		9.0 mm	All Holes 2 20 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		11	7	25			
	Inspected By (Sign) & Date		Ravi 11/7/25					

Satya 11/7/25

Reviewed by (Engineer-CNC)

Manager-QA