10324

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.		15432	35/40/66
2	Machined By		V.T.L. H/C Shop	Dy No. 18.0.609
3	Pallet Die No.		15206 (6.0) 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.	546.14 mm (Bor, 548.4 mm)	Step length. 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Undercut, 2.5 mm
8	Grooves as per Drawing	Drg. No.	32x7x9.2 mm / 32x7x9.2 mm	(4x8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side step 8 mm Deep Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 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. 33.6 mm	Tapping Depth 31.6 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 22/7/25	
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

1	Counter Sinking Depth & Finish	ok						Counter, 30 Row. 12
2	External Relief Dia	6.5 mm / 4.0 mm	6.5 mm	All Holes 2 31 mm				
3	External Relief Depth		4.0 mm	All Holes 2 26 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		22	7	25			
	Inspected By (Sign) & Date		Ravi 22/7/25					

Satya 22/7/25

Reviewed by (Engineer-CNC)

Manager-QA