10362

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.		15400	36/50
2	Machined By		V.T.L M/c Shop	Dy. No. Ledgel 480
3	Pallet Die No.		15971 (3.0) mm	Row 2 03
4	Die Category	Drg. No.	M7&8	
5	Out Side Diameter	Drg. No.	701 mm, Step OD: 703 mm	Tapper: 12
6	Inside Diameter	Drg. No.	600.14 mm	Step length 17.4
7	Width of Pellet Die	Drg. No.	265.6 mm	Undercut = 1 mm
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 7 mm / 15.3 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step
10	Drilling Area Surface Smoothness		ok	0.8 mm Deep
11	Tapping Operator		M/c. Shop	Both Side
12	Tapping PCD		640 mm	Tapping
13	Tapping Hole Diameter		M20 Check by M20 Bolt	of holes 16
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 20.8 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 25/7/25	
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: Go Row 4 7
2	External Relief Dia	3.5 mm	Outside (3.3)		Inner			
3	External Relief Depth		20 mm		14 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		25	7	25			
	Inspected By (Sign) & Date		Ravi 25/7/25					

Satya 25/7/25.

Reviewed by (Engineer-CNC)

Manager-QA