10371

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.		15499	48/55
2	Machined By		V.T.L H/C Shop	Dy No. 13.6.055
3	Pallet Die No.		13901 (4.0) mm	Rev 100
4	Die Category	Drg. No.	SS370	
5	Out Side Diameter	Drg. No.	630 mm Step OD 611.9 mm	Step length 20
6	Inside Diameter	Drg. No.	520.14 mm	
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 3 mm / 13 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of Holes 12 Both Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm Tapping Depth 184	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 26/7/25	
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 = 60 Ravi 25

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.5 mm	Outside (3.3)		Inner			
3	External Relief Depth		17 mm		13 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		26	7	25			
	Inspected By (Sign) & Date		Ravi 26/7/25					

26/7/25

Reviewed by (Engineer-CNC)

Manager-QA