10383

Lark Engineering Company (India) Pvt. Ltd.	Form No.	CNC/QA/FM/02
I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)	Rev. No.	01
Inprocess Inspection (Pellet Dies)	Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15638	30/66
2	Machined By		V.T.L. H/C Shop	Depth 13.0 330
3	Pallet Die No.		15557 (6.0) HH	Rev. 08
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.2 HH, Step OD. 692.8 HH	Tapper 3°
6	Inside Diameter	Drg. No.	546.12 HH (Bore = 548.2)	Step length 31 HH
7	Width of Pellet Die	Drg. No.	195 HH	Undercut = 2.7 HH
8	Grooves as per Drawing	Drg. No.	32×7×9.1 HH / 32×7×9.1 HH	(4×8) HH
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 HH Deep Body Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 HH	Tapping No of Holes 2 Body 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 33.7 HH	Tapping Depth 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 29/7/25	
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 Rev. 12

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	7.0 HH		All Rows				
3	External Relief Depth			36 HH				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		29	7	25			
	Inspected By (Sign) & Date		Ravi 29/7/25					

29/7/25.

Reviewed by (Engineer-CNC)

Manager-QA