10455

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.		15546	39/50
2	Machined By		V.T.L. M/C. Shop	Drg. No. 1.8G/48
3	Pallet Die No.		15974 (3.0) mm	Rev. 03
4	Die Category	Drg. No.	MYE 10	
5	Out Side Diameter	Drg. No.	701 mm, Step OD = 703 mm	Tapper 2°
6	Inside Diameter	Drg. No.	600.14 mm (Bor. 599.6)	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
10	Drilling Area Surface Smoothness		ok	Step 0.8 mm
11	Tapping Operator		M/C. Shop	Back Side
12	Tapping PCD		640 mm	Tapping No.
13	Tapping Hole Diameter		M20 x 1 Check by M20 Bolt	of Holes 18
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 20.5 mm	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 8/8/25	
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. 60° Rev. 47
2	External Relief Dia	3.5 mm	Outside (3-3)		Inner			
3	External Relief Depth		17 mm		11 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		8	8	25			
	Inspected By (Sign) & Date		Ravi 8/8/25					

8/8/25

Reviewed by (Engineer-CNC)

Manager-QA