10475

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.		15600/	60/60
2	Machined By		V.T.L. M/C Shop	Dy. No. LS.1408
3	Pallet Die No.		15512(12.0)/	Rev 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	719.9 mm/ Step OD 692.9 mm/	
6	Inside Diameter	Drg. No.	600.14 mm/	Tapper: 12°
7	Width of Pellet Die	Drg. No.	222 mm/	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 mm / 12 x 8 x 7 mm/	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		640 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 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 13/8/25	
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° Roll
2	External Relief Dia	12.5 mm/	Outside 13.3		Inner			
3	External Relief Depth		5 mm/		Mill/			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		13	8	25			
	Inspected By (Sign) & Date		Ravi 13/8/25					

Satyam 13/8/25
Reviewed by (Engineer-CNC)

Manager-QA