10573

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.		15795	55/Go
2	Machined By		V.T.L m/c Shop	Dy No. 18.04.11
3	Pallet Die No.		15945 (5.0) mm	Rev. 70
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 mm, Step OD, 792 mm, Step length 96	
6	Inside Diameter	Drg. No.	680.14 mm	Undercut, 6 mm
7	Width of Pellet Die	Drg. No.	324 mm	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 mm / 21.5 x 8 x 8 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		725 mm	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 31.4 mm	Tapping Depth 28.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 2/9/25	
1	As per programme no.		—	2 Slot 32.1 mm width 8 mm Deep Both Side
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. Go Rev. 40

1	Counter Sinking Depth & Finish	Ok					
2	External Relief Dia	5.5 mm	Outside (3-3)		Inner		
3	External Relief Depth		15 mm		5 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		2	9	25		
	Inspected By (Sign) & Date		Ravi 2/9/25				

Reviewed by (Engineer-CNC) 2/9/25.

Manager-QA