10648

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.		18031	33166
2	Machined By		V.T.L M/c Shop	Dry No = 18.0, 6.9
3	Pallet Die No.		15867 (6.0) mm	Row 03
4	Die Category	Drg. No.	H. Jumbo	Groove 4 x 3
5	Out Side Diameter	Drg. No.	680.7 mm Step OD =	692.9 mm Tapper = 8°
6	Inside Diameter	Drg. No.	546.14 mm (Box. 548.4)	Step length = 3 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut = 0.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm / 32 x 7 x 9.2 mm	(4 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step 4 mm
10	Drilling Area Surface Smoothness		OK	Depth Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		618.9 mm	of Holes = 2
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 33.6 mm	Tapping depth = 31.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi 15/9/25	
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 = 30° Row = 12
2	External Relief Dia	7.5 mm		All Rows				
3	External Relief Depth			33 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			15	9	25		
	Inspected By (Sign) & Date		Ravi 15-9-25					

Satish 19/9/25

Reviewed by (Engineer-CNC)

Manager-QA