10694

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.		15888	42/45
2	Machined By		V.T.L M/c Shop	Dry No = 1.8.0=541
3	Pallet Die No.		14905 (3.5) mm	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	409.9 mm Step OD = 394.9 mm	
6	Inside Diameter	Drg. No.	320.14 mm	Step length 14.5 mm
7	Width of Pellet Die	Drg. No.	142 mm	
8	Grooves as per Drawing	Drg. No.	15.5x7x2 mm / 15.5x7x2 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 Hole = 8 Both Side
12	Tapping PCD		355 mm	
13	Tapping Hole Diameter		M16 = Black by M16 = Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.5 mm	Tapping depth = 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi 20/9/25	
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 = 60° Row = 18
2	External Relief Dia	4.0 mm	Outside 2-2		Inner			
3	External Relief Depth		10 mm		3 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			20	9	25		
	Inspected By (Sign) & Date		Ravi 29/9/25					

29/9/25.

Reviewed by (Engineer-CNC)

Manager-QA