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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.			
2	Machined By		16241 ✓	19/60 ✓
3	Pallet Die No.		V. T. L. n/c Shop	19/60 ✓
4	Die Category	Drg. No.	16459 (6.0) ✓	Rev 103 ✓
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.7 mm ✓	Step 02. 693 mm ✓
7	Width of Pellet Die	Drg. No.	546.12 mm (Ber. 548.4) ✓	Tapping 2 8°
8	Grooves as per Drawing	Drg. No.	195 mm ✓	Step length = 0.5
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.2 mm 32.7 x 9.2 mm (4 x 8) ✓	
10	Drilling Area Surface Smoothness		ok	2 mm Deep
11	Tapping Operator		n/c Shop	Both Side
12	Tapping PCD		619 mm ✓	Tapping 2
13	Tapping Hole Diameter		M16 2 Crack by M16 Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth. 33.4 mm ✓	Tapping Depth 31.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 9/10/25	
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			Counter 30°
2	External Relief Dia	7.5 mm ✓	All Rows	Row 212
3	External Relief Depth		47 mm ✓	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Poragae	
6	Material Sent For Hardening On Date		9 10 25	
Inspected By (Sign) & Date			Ravi 9/10/25	

Reviewed by (Engineer-CNC)

Manager-QA