10879

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		16241	17166
2	Machined By		V.T.L M/C Shop	Drg No. LS.D.609
3	Pallet Die No.		16467 (6.0) mm	Rev. 03
4	Die Category	Drg. No.	Mi Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm Step OD 693 mm	Tapper 8°
6	Inside Diameter	Drg. No.	546.14 mm (Bore 548.4) mm	Step length 31 mm
7	Width of Pellet Die	Drg. No.	194.9 mm	Under cut 2.5 mm
8	Grooves as per Drawing	Drg. No.	32×7×9.2 mm / 32×7×9.2 mm	(4×2) mm
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	Race Side Step 9 mm Back Side
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		619 mm	Tapping No of holes 2 Both Side
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
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 14/10/25	
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	Ok						Counter Bo Rev. 12
2	External Relief Dia	7.5 mm		All Holes				
3	External Relief Depth	✓		49 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		14	10	25			
	Inspected By (Sign) & Date		Ravi 14/10/25					

14/10/25

Reviewed by (Engineer-CNC)

Manager-QA