10877

Lark Engineering Company (India) Pvt. Ltd.	Form No.	CNC/QA/FM/02
I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)	Rev. No.	01
Inprocess Inspection (Pellet Dies)	Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16282	91/66
2	Machined By		V.T.L. M/c Shop	83/66
3	Pallet Die No.		16267 (6.0) HM	Dgn. 120889
4	Die Category	Drg. No.	M. Jumbo	Rev. 03
5	Out Side Diameter	Drg. No.	680.7 HM Step OD - 693 HM	Tapper 2°
6	Inside Diameter	Drg. No.	546.14 HM (Box. 548.4)	Step length 31 HM
7	Width of Pellet Die	Drg. No.	195 HM	Under cut 2.5 HM
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 HM / 32 x 7 x 9.2 HM	(4 x 8) HM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	8 HM Deep Both
11	Tapping Operator		M/c Shop	Side
12	Tapping PCD		619 HM	Tapping No
13	Tapping Hole Diameter		M16, Check 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 HM	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

Counter Bo

1	Counter Sinking Depth & Finish	ok						Rev. 12
2	External Relief Dia	7.0 HM	1st Pad All Holes 45 HM		4th Pad All Holes 43 HM			
3	External Relief Depth							
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Romaca					
6	Material Sent For Hardening On Date		14	10	25			
	Inspected By (Sign) & Date		Ravi 14/10/25					

Satya 14/10/25

Reviewed by (Engineer-CNC)

Manager-QA