10883

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
Inprocess Inspection (Pellet Dies)		Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16299 to 16378	30/66
2	Machined By		V.T.L M/c Shop	Dy No 1&D. 32
3	Pallet Die No.		16469 (6.0) mm	Rev. 08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm, Step OD. 692.9 mm	Tapper 8°
6	Inside Diameter	Drg. No.	546.14 mm, (Bore, 548.2)	Step length 3 mm
7	Width of Pellet Die	Drg. No.	194.9 mm	Width cut 9.8 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 mm / 32 x 7 x 9.1 mm	(4 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep
11	Tapping Operator		M/c Shop	Both Side
12	Tapping PCD		619 mm	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 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	7.0 mm		All Rows				
3	External Relief Depth			36 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					

Satya 14/10/25

Reviewed by (Engineer-CNC)

Manager-QA