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.		10417	33/66
2	Machined By		V.T.L. M/c Shop	Drg No. LS.O. 609
3	Pallet Die No.		11192 (6.0) mm	Rev. 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 mm, Step OD. 693 mm	Tapper 8°
6	Inside Diameter	Drg. No.	548.12 mm	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut. 2.5 mm
8	Grooves as per Drawing	Drg. No.	32x7x8 mm / 32x7x8 mm (4x8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Face Side Step 2 mm
10	Drilling Area Surface Smoothness		ok	Deep Both Side]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619 mm	[Tapping No of
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	Holes = 4 Both Side]
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 mm Tapping Depth = 31.8 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 25/11/23	
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 = 30° Row = 12
2	External Relief Dia	7.5 mm	All Lines					
3	External Relief Depth		33 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							
	Inspected By (Sign) & Date							

Satya 25/11/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner