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.		10933	40/66
2	Machined By		V.T.L M/c Shop	Drg No. L.S.D. 609
3	Pallet Die No.		11493 (10.0) MM	Rev 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 Step OD = 692.8 MM Groove = 4×3	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.	32×7×8 MM / 32×7×8 MM	(4×8) MM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 MM Deep Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No of Holes = 4 Both Side
12	Tapping PCD		619 MM / 618.9 MM	
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 = 34 MM Tapping Depth = 31.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 29/12/23	
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 = 60° Row = 8
2	External Relief Dia	11.0 MM	All Rows					
3	External Relief Depth		28 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		29	12	23			
	Inspected By (Sign) & Date		Ravi 29/12/23					

Satya 29/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner