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.		11132	28/38/66
2	Machined By		V.T.L M/c Shop	Drg No. 1.8.D.609
3	Pallet Die No.		11477 (6.0) MM	Rev 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 MM, Step OD = 692.8 MM	Tapper 8°
6	Inside Diameter	Drg. No.	548.12 MM	Step length = 31 MM / 35
7	Width of Pellet Die	Drg. No.	195 MM	Undercut = 2.4 MM
8	Grooves as per Drawing	Drg. No.	32x7x8 MM / 32x7x8 MM	(4x8) Face side Step 2 MM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Deep Both side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No.
12	Tapping PCD		619 MM	of holes 4
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 MM	Tapping Depth = 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 2/2/24	
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	6.5 MM / 7.0 MM	6.5 MM	All Rows	7.0 MM	All Rows		
3	External Relief Depth		38 MM			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		2	2	24			
	Inspected By (Sign) & Date		Ravi 2/2/24					

Satya 2/2/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner