10279

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
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15189	45/60
2	Machined By		V.T.L. M/c Shop	Drg No. LS.01343
3	Pallet Die No.		15943 (8.0) mm	Rev: 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm, Step OD. 798mm	Tapper. 4°
6	Inside Diameter	Drg. No.	680.14mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	323.9mm	Undercut. 9mm
8	Grooves as per Drawing	Drg. No.	21.5×8×7mm / 21.5×8×7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/c Shop	Tapping M. of Holes 12 Both Side
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M20 Check by M20 B.H	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 30.4mm	Tapping Depth 25.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 16/7/25	
1	As per programme no.		—	2 Slot 32.1mm width 8mm Deep Both Side
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. 60°

1	Counter Sinking Depth & Finish	Ok.						Rad: 27
2	External Relief Dia	8.5mm	Outside 23.31		Inner			
3	External Relief Depth		23mm		15mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		16	7	25			
	Inspected By (Sign) & Date		Ravi 16/07/25					

Satya 16/7/25.

Reviewed by (Engineer-CNC)

Manager-QA