10720

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.		15880	48/55
2	Machined By		V.T.L M/c Shop	Dry No: L.E.C.18381
3	Pallet Die No.		15580 (6.0) mm	Rev: 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530 mm Step OD = 490.9 mm	
6	Inside Diameter	Drg. No.	420.14 mm	Step length. 17.5
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm / 12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No of Holes = 8 Both side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.4 mm	Tapping depth = 16.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi 23/9/25	
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

Counter = 65
Recv. = 15

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5 mm	Outside (2.2)	Inner			
3	External Relief Depth		13 mm	7 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		23	9	25		
	Inspected By (Sign) & Date		Ravi 23-9-25				

23/9/25.

Reviewed by (Engineer-CNC)

Manager-QA