



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.		9894 to 10094	33/43/66
2	Machined By		V.T.L n/c Shop	Drg No. 1.99.609
3	Pallet Die No.		10585 (6.0) n/c	Rev 2.01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 n/c Step OD = 699 n/c	Step length = 31 n/c
6	Inside Diameter	Drg. No.	548.12 n/c	Tap = 3°
7	Width of Pellet Die	Drg. No.	194.9 n/c	Under cut = 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c 31.8 x 7 x 8 n/c (4 x 8)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Face Side step 9 n/c Deep Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	[Tapping No of holes = 4 Both Side]
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 = 33 n/c Tapping Depth = 31.6 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 8/8/23	
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	6.5 n/c 7.3 n/c	6.5 n/c All Lines 7.3 n/c All Lines	
3	External Relief Depth		33 n/c 23 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Forcase	
6	Material Sent For Hardening On Date		8 / 8 / 23	
Inspected By (Sign) & Date			Ravi 8/8/23	

Reviewed by (Engineer-CNC)

Manager-QA