



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12912	30/66
2	Machined By		V.T.L. n/c Shop	Drill, 1.3.0 = 380
3	Pallet Die No.		12951 (6.0) n/c	Row 05
4	Die Category	Dr. No.	N. Jumbo	to LSD-609 (Per/02)
5	Out Side Diameter	Dr. No.	680.1 n/c	Step 00 - 693 n/c Tapper 2.8
6	Inside Diameter	Dr. No.	548.1 n/c	Step length = 31 n/c
7	Width of Pellet Die	Dr. No.	195 n/c	Under cut = 2.5 n/c
8	Grooves as per Drawing	Dr. No.	32 x 7 x 8 n/c	32 x 7 x 8 n/c (4.08) n/c
9	Fitting Sizes on CNC Plate	Dr. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2.4 n/c Deep Both Side
11	Tapping Operator		n/c Shop	Tapping No
12	Tapping PCD		619 n/c	of holes, 4
13	Tapping Hole Diameter		M16 2	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 34.8 n/c	Tapping Depth, 32 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/9/24

1	As per programme no.			Final
2	Gun Drilling Work Completed On			Fitting Size
3	Hole Finish In Gun Drilling	Marked	ok	Drill = 609
4	Defective Holes (If Any)		No	Row 02

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok					Counter, 30
2	External Relief Dia	7.0 n/c	All Rows				Row = 12
3	External Relief Depth		36 n/c				
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark furnace				
6	Material Sent For Hardening On Date		21	9	24		

Inspected By (Sign) & Date

Ravi 21/9/24

Reviewed by (Engineer-CNC)

Manager-QA