



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.		12913	25/25/06
2	Machined By		V. T. L. H/c. Shop	23/33/06
3	Pallet Die No.		13341 (6.0) mm	Counters 30° Recess
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm	Step 0.0, 693 mm Tappet 8°
6	Inside Diameter	Drg. No.	548.0 mm / 547.1 mm	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 mm / 32 x 7 x 8 mm	(4 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step Down Back Both side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c. Shop	
12	Tapping PCD		619 mm	Tapping No of holes 9
13	Tapping Hole Diameter		4.16 = Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 34.8 mm	Tapping Depth = 32 mm
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.		
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				Counters 30° Recess
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm = 4 mm	6.5 mm = 4.3 mm		
3	External Relief Depth	1.0 mm / 3.1 mm	1.0 mm = 3.1 mm			
4	Inspection Done Before Hardening By (Name)					Ravi
5	Material Sent For Hardening By (Name)					Lark Forward
6	Material Sent For Hardening On Date		21	9	24	

Inspected By (Sign) & Date

Ravi 21/9/24

Reviewed by (Engineer-CNC)

Manager-QA