



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.		12956	28/08/16
2	Machined By		V.T.L. M/C Shop	Dry No. 1.S.O. 809
3	Pallet Die No.		13334 (6.0) M/C	Revised
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 M/C Step OD: 693 M/C	Tabber 8°
6	Inside Diameter	Drg. No.	547.12 M/C 547.9 M/C	Step length 31 M/C
7	Width of Pellet Die	Drg. No.	195 M/C	Under cut 2.5 M/C
8	Grooves as per Drawing	Drg. No.	32.7 x 8 M/C 32.7 x 8 M/C	(4 x 2) M/C
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Face side step] [2 M/C Reck] [Both side] [Tapping M/C] [of holes &] [Both side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		819 M/C	
13	Tapping Hole Diameter		M16 - Check by M16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 34.8 M/C	Tapping Depth: 32 M/C
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/10/24

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

Counter: 30

1	Counter Sinking Depth & Finish	OK								Row = 12
2	External Relief Dia	6.5 M/C 7.0 M/C	6.5 M/C	All Rows	7.0 M/C	All Rows				
3	External Relief Depth		38 M/C			38 M/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		14	10	24					

Inspected By (Sign) & Date

Ravi 14/10/24

Reviewed by (Engineer-CNC)
S. J. Singh 14/10/24

Manager-QA