



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.			
2	Machined By		12956	28/08/06
3	Pallet Die No.		V.T.L. n/c Shop	Dry No. 1.2.0.809
4	Die Category	Drg. No.	13336 (6.0) n/c	Rev. 02
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.7 n/c Step 00 - 893 n/c	Tapless 8°
7	Width of Pellet Die	Drg. No.	547.12 n/c / 547.9 n/c	Step length 91 n/c
8	Grooves as per Drawing	Drg. No.	195 n/c	Under cut = 2.5 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	327.7 x 8 n/c / 327.7 x 8 n/c	4 x 8 n/c
10	Drilling Area Surface Smoothness		ok	Face side Step 2 n/c Rasp Both Side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	Tapping n/c of Holes - 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
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				Counters 30
1	Counter Sinking Depth & Finish	ok		Row = 12
2	External Relief Dia	6.3 n/c / 7.0 n/c	6.5 n/c All Rows / 7.0 n/c All Rows	
3	External Relief Depth		38 n/c / 38 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		14 / 10 / 24	
Inspected By (Sign) & Date			Ravi 14/10/24	

Reviewed by (Engineer-CNC)

Manager-QA