



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.		13007	As per Drg: 41/65
2	Machined By		V. T. L n/c Shop	Drg No: 1.2.9.788
3	Pallet Die No.		13619 (6.0) n/c	Rev. 01
4	Die Category	Dr. No.	M. Jumbo	
5	Out Side Diameter	Dr. No.	678 n/c Step OD = 698 n/c	Step length = 38 n/c
6	Inside Diameter	Dr. No.	Bo = 548.12 n/c ID Step = 546.12 n/c	
7	Width of Pellet Die	Dr. No.	195 n/c	Loaden cot = 4.9 n/c
8	Grooves as per Drawing	Dr. No.	31x8x8 n/c 31x8x8 n/c	5x8 n/c
9	Fitting Sizes on CNC Plate	Dr. No.	ok	[Face side Step]
10	Drilling Area Surface Smoothness		ok	[1 n/c Deep Both Side]
11	Tapping Operator		n/c Shop	[Tapping No]
12	Tapping PCD		619 n/c	[of holes = 2]
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	[Both Side]
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 38.8 n/c	Tapping Depth = 36.4
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				
1	Counter Sinking Depth & Finish	ok	Counters = 30 Rows = 12	
2	External Relief Dia	7.0 n/c	All Rows	
3	External Relief Depth		24 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