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.		13050	30/66
2	Machined By		V.T.L H/C Shop	Drg No. LS.D.609 Rev. 09
3	Pallet Die No.		13323 (6.0) MM	
4	Die Category	Drg. No.	N. Jumbo Groove 4+3	
5	Out Side Diameter	Drg. No.	680.7 MM, Step OD = 693 MM	Tapper = 8°
6	Inside Diameter	Drg. No.	548.1 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.	32×7×8 MM | 32×7×8 MM	(4×8) MM
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	Face Side Step 8 MM Deep Both Side
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 MM	Tapping No. of Holes = 2 Both Side
13	Tapping Hole Diameter		M16 : Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 34.8 MM Tapping Depth = 31.8 MM	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 15/10/24	
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						Counter = 30° Rows. 12
2	External Relief Dia	7.0 MM	7.0 MM	All Rows				
3	External Relief Depth			36 MM				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		15	10	24			
	Inspected By (Sign) & Date		Ravi 15/10/24					

Satya 15/10/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner