



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		13153	55/66
3	Pallet Die No.		V.T.L. N/C Shop	Dy No. 1.8.0-39
4	Die Category	Drg. No.	12945 (8.0mm)	Rev 206
5	Out Side Diameter	Drg. No.	M. Jamba	
6	Inside Diameter	Drg. No.	680.1mm Step 00, 692mm	Tapless 8°
7	Width of Pellet Die	Drg. No.	548mm	Step length 31mm
8	Grooves as per Drawing	Drg. No.	195mm	31.4mm
9	Fitting Sizes on CNC Plate	Drg. No.	32x7x8mm 32x7x8mm (4x8)mm	
10	Drilling Area Surface Smoothness		ok	[Face side step 8mm Deep Both Side]
11	Tapping Operator		N/C Shop	
12	Tapping PCD		619mm	[Tapping No of holes 2 Both Side]
13	Tapping Hole Diameter		M16 2 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 34mm	Tapping Depth: 31.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/10/24

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
Ravi 10

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	9.0mm	All Rows				
3	External Relief Depth		11mm				
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		21	10	24		

Inspected By (Sign) & Date

Ravi 21/10/24

Reviewed by (Engineer-CNC)

Manager-QA