



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13078 ✓	35/83/78 ✓
2	Machined By		V.T.L. n/c Shop	Drg. No. 630.99C
3	Pallet Die No.		13818 (6.5) mm ✓	Rev. 2.0 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	636 mm ✓	Step OD: 630.5 mm / 543 mm ✓
6	Inside Diameter	Drg. No.	632 mm ✓	480.1 mm / Step ID: 489.1 / 500. Step length: 28.4 mm ✓
7	Width of Pellet Die	Drg. No.	182 mm ✓	16.5 mm ✓
8	Grooves as per Drawing	Drg. No.	37 x 12 + 8 x 9.5 mm / 27 x 12 x 8 x 9.5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		540 mm ✓	Tapping No. of Holes: 4
13	Tapping Hole Diameter		M16 Check by M16 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and the side one slot	
15	Tapping Hole Depth		Drill Depth: 28.4 mm	Tapping Depth: 26.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/10/24

1	As per programme no.			1 Slot 28.1 mm width 17 mm Depth
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 9
2	External Relief Dia	1.0 mm / 1.5 mm	1.0 mm All Rows	1.5 mm All Rows						
3	External Relief Depth	✓	43 mm	15 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		19	10	24					

Inspected By (Sign) & Date

Ravi 19/10/24

Sobhan 19/10/24

Reviewed by (Engineer-CNC)

Manager-QA