



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.		12543 / 1013167	24/34/66
2	Machined By		V.T.L. M/C Shop	28/36/66
3	Pallet Die No.		12942 (8.0) mm	Dry Run (L.S.D.) 609
4	Die Category	Drg. No.	M. Jumbo	Recessed
5	Out Side Diameter	Drg. No.	680.7 mm	Step 00 - 693 mm
6	Inside Diameter	Drg. No.	548 mm	Topless 809
7	Width of Pellet Die	Drg. No.	195 mm	Step length = 31 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 mm	Undercut = 2.5 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 8 mm	(4 x 8) mm
10	Drilling Area Surface Smoothness		OK	[Face side Step 2mm Deep Both Side]
11	Tapping Operator		M/C Shop	
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	[Tapping No of holes = 4]
14	Tapping On Second Side	Half pitch of 1st side	OK	[Both Side]
15	Tapping Hole Depth		Drill Depth = 34 mm	Tapping Depth = 31 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Res: 28/10/24

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

Count as 30

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	8.5 mm / 9.0 mm	1st Pad 4.2 mm	2nd Pad 4.0 mm					
3	External Relief Depth		8.5 mm / 9.0 mm	3.8 mm	8.5 mm / 9.0 mm	3.0 mm			
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Burnare
6	Material Sent For Hardening On Date		28	10	24				

Inspected By (Sign) & Date

Res: 28/10/24

Reviewed by (Engineer-CNC)

Manager-QA