



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

5600

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.		9614	25/35/66
2	Machined By		V. T. L H/c Shop	Drg No. 12.0.609
3	Pallet Die No.		10255 (G.0) mm	Rev. 01
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.6 mm Step 08 + 693 mm	Tapper = 8°
6	Inside Diameter	Drg. No.	548.12 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 x 7 x 8 mm (4 x 8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side Step 2 mm
10	Drilling Area Surface Smoothness		OK	Back Side
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		N/G = Check by H/G Ball	Tapping No. of Holes = 4
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth = 33.4 mm	Tapping Depth = 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date Ravi 31/6/23				
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°
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm All Lines	7.0 mm All Lines
3	External Relief Depth		4 mm	31 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For name	
6	Material Sent For Hardening On Date		3 6 23	
Inspected By (Sign) & Date Ravi 31/6/23				

Reviewed by (Engineer-CNC)

Manager-QA