



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.		12685	80/65.5
2	Machined By		V. T. L. Nk Shop	Dy No. 130902
3	Pallet Die No.		13613(12-0)M	Rev 02
4	Die Category	Drg. No.	33970	
5	Out Side Diameter	Drg. No.	639.7 mm Step 00.64.7 mm / 523 apbbs	
6	Inside Diameter	Drg. No.	508.8 mm / Step 2 520.12 mm / 539.7 mm	
7	Width of Pellet Die	Drg. No.	175 mm	Under cut 1 mm
8	Grooves as per Drawing	Drg. No.	30x21x7.5 mm / 9x25 mm	Step length 32 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of holes 4
12	Tapping PCD		574 mm	
13	Tapping Hole Diameter		N/C Check by N/C Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 1/2nd Side	
15	Tapping Hole Depth		Drill Depth 30 mm	Tapping Depth 38.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Soni 11/11/24

4 Slot
51.5 long
88 mm wide
15 mm Deep

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		None

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 80

1	Counter Sinking Depth & Finish	OK								Row 2 5
2	External Relief Dia	12.5 mm	All Rows							
3	External Relief Depth		5.5 mm							
4	Inspection Done Before Hardening By (Name)		Soni							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		"	"	24					

Inspected By (Sign) & Date

Soni 11/11/24

Reviewed by (Engineer-CNC)

Manager-QA