

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		13494 ✓	28/31/66
3	Pallet Die No.		V.T.L. NLC Shop	Drill No. 13.0.809
4	Die Category	Drg. No.	13796 (6.0) ✓	Rev 203 ✓
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.7 ✓ / Step 00, 693 ✓	Tap per 8°
7	Width of Pellet Die	Drg. No.	546.12 ✓ (548.12)	Step length 31.4 ✓
8	Grooves as per Drawing	Drg. No.	195 ✓	Under cut 2.5 ✓
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 & 9.1 ✓ 32.7 & 9.1 ✓	(4 & 8) ✓
10	Drilling Area Surface Smoothness		ok	Face Side ✓ Back Side ✓
11	Tapping Operator		ok	
12	Tapping PCD		NLC Shop	
13	Tapping Hole Diameter		619 ✓	Tapping No.
14	Tapping On Second Side	Half pitch of 1st side	MIG - Check by MIG Bolt	of Holes - 2
15	Tapping Hole Depth		ok	Back Side
16	Perpendicularity of Tapped Hole		Drill Depth = 33.4 ✓	Tapping Depth 31.6 ✓
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 10/12/24

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

1	Counter Sinking Depth & Finish	ok					Counter 30
2	External Relief Dia	6.5 ✓ / 7.0 ✓	6.5 ✓ All Rows	2.98 ✓			Row 12
3	External Relief Depth		4.0 ✓ All Rows	2.98 ✓			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		10	12	24		

Inspected By (Sign) & Date

Ravi 10/12/24

Reviewed by (Engineer-CNC)

Manager-QA