



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.		13555	35/45/66
2	Machined By		V.T.L. N/C Shop	33/43/66
3	Pallet Die No.		13791(6.0)mm	Dy. 1.2.0.3
4	Die Category	Drg. No.	N. Jumbo	Rev. 08
5	Out Side Diameter	Drg. No.	680.1mm Step 002 693mm	Tapper 8°
6	Inside Diameter	Drg. No.	546.12mm (Bore 543.12)	Step length 31mm
7	Width of Pellet Die	Drg. No.	195mm	Under cut 2.3mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1mm 32 x 7 x 9.1mm	(4 x 2)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		N/C Shop	2mm Deep Bore Side
12	Tapping PCD		619mm	Tapping No
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Bore Side
15	Tapping Hole Depth		Drill Depth 33.3mm Tapping Depth 31.5mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/12/24

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	6.5mm 7.0mm	1st Rod 6.5mm = 31mm	2nd Rod 7.0mm = 31mm	1st Rod 6.5mm = 33mm	2nd Rod 7.0mm = 33mm			Rep 2 12°
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		14	12	24				

Inspected By (Sign) & Date

Ravi 14/12/24

Satyam 14/12/24

Reviewed by (Engineer-CNC)

Manager-QA