

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		13564 ✓	83/66
3	Pallet Die No.		V.T.C. H/c Shop	Drg No. 13.0.2.609
4	Die Category	Drg. No.	13331 (10.0) H/c	Rev: 02
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	680.7 H/c → Step 002 → 693 H/c	Tappers = 8°
7	Width of Pellet Die	Drg. No.	548.1 H/c	Step length = 31 H/c
8	Grooves as per Drawing	Drg. No.	195 H/c	Under cut = 2.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 8 H/c 32 x 7 x 8 H/c	(Cure)
10	Drilling Area Surface Smoothness		ok	Face Side Step 2 H/c Deck Both Side
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c ✓	Tapping No of Holes = 2 Both Side
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.3 H/c	Tapping Depth = 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/12/24

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

Counter = 60°
Len = 8

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	11.0 H/c	11.0 H/c	All Roots			
3	External Relief Depth			3 H/c			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		11	12	24		

Inspected By (Sign) & Date

Ravi 11/12/24

Reviewed by (Engineer-CNC)

Manager-QA