



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.		13439	55/100
2	Machined By		V. T. L. N/C Shop	Drg. No. 1.20.9743
3	Pallet Die No.		13938 (8.0)mm	Rev. 03
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1051mm, Step OD = 1041.84mm	Tabbers 4°
6	Inside Diameter	Drg. No.	851.12mm [10 Step Tabbers = 15°]	Step length = 32.5
7	Width of Pellet Die	Drg. No.	251mm	Length = 17.1mm
8	Grooves as per Drawing	Drg. No.	50x11x10.5mm 50x14x10.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		958mm	Tapping No of holes = 24 Both Side
13	Tapping Hole Diameter		M302 Check by M30 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 43.5mm	Tapping Depth = 43mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rev: 17/12/24	
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 Row = 12
2	External Relief Dia	9.0mm	All Rows	
3	External Relief Depth		45mm	
4	Inspection Done Before Hardening By (Name)		Rev:	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		17	12
Inspected By (Sign) & Date			Rev: 17/12/24	

Reviewed by (Engineer-CNC)

Manager-QA