



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		13568	33/45/65
3	Pallet Die No.		V.T.L. N/C Shop	Dr. No. 18.984
4	Die Category	Drg. No.	12070 (G.O) H/T	Row 01
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	829.9mm, Step OD = 808.9mm	Tapper = 12°
7	Width of Pellet Die	Drg. No.	700.12mm	Step length = 40.9mm
8	Grooves as per Drawing	Drg. No.	340mm	
9	Fitting Sizes on CNC Plate	Drg. No.	37x8x12mm 37x8x12mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		742mm	Tapping No. of holes = 12 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 = 25.3mm	Tapping Depth = 23.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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 60
2	External Relief Dia	6.5mm 6.8mm	6.5mm	All Rows = 232mm				Row 32
3	External Relief Depth		6.8mm	All Rows = 20mm				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		17	12	24			

Inspected By (Sign) & Date

Ravi 17/12/24

Reviewed by (Engineer-CNC)

Manager-QA