



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.		13508	60/65.5
2	Machined By		V.T.L. n/c Shop	Dy. No. 13.02.90
3	Pallet Die No.		14077(12.0)MM	Rev: 03
4	Die Category	Drg. No.	38870	
5	Out Side Diameter	Drg. No.	639.6MM Step OD = 652.2MM	Tapper 8°
6	Inside Diameter	Drg. No.	508.8MM (10 Step - 539.7/533.3MM)	Step length = 33MM
7	Width of Pellet Die	Drg. No.	175MM	
8	Grooves as per Drawing	Drg. No.	30x21x7.25MM / 9x25MM	Face Side
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Step 0.5MM Deep
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No.
12	Tapping PCD		574MM	of holes = 4
13	Tapping Hole Diameter		MIG, Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 2nd Side 4 slot	
15	Tapping Hole Depth		Drill Depth = 30.3MM Tapping Depth = 28.7MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Pasi 18/12/24

1	As per programme no.			4 slot
2	Gun Drilling Work Completed On			51.5MM Long
3	Hole Finish In Gun Drilling	Marked	ok	28.1MM width
4	Defective Holes (If Any)		No.	15MM Deep

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 6°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	12.5MM	All Rnds							
3	External Relief Depth		5.5MM							
4	Inspection Done Before Hardening By (Name)		Pasi							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		18	12	24					

Inspected By (Sign) & Date

Pasi 18/12/24

Reviewed by (Engineer-CNC)

Manager-QA