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.		13576	40/60/66
2	Machined By		V.T.L M/C Shop	Drg No. LS.D-609
3	Pallet Die No.		13930 (6.0) MM	Rev 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 MM, Step OD Grooves 4x3 693 MM	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 MM (Bar 548.12 MM)	Step length 31 MM
7	Width of Pellet Die	Drg. No.	195 MM	Under cut 2.5 MM
8	Grooves as per Drawing	Drg. No.	32x7x9.2 MM / 32x7x9.2 MM	(4x3) MM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 MM Deep
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		619 MM	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	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 MM Tapping Depth 31.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 16/12/24	
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° Rows 12
2	External Relief Dia	6.5 MM / 7.0 MM	6.5 MM All Rows = 26 MM					
3	External Relief Depth		7.0 MM All Rows = 6 MM					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		16	12	24			
	Inspected By (Sign) & Date		Ravi 16/12/24					

Satya 16/12/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner