



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.		13632	35/45/55
2	Machined By		V.T.L. H/C Shop	Drg. No. 1.2.0-407
3	Pallet Die No.		14138 (4.0) mm	Rev 2.00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	710 mm	Step on 693 mm
6	Inside Diameter	Drg. No.	600.12 mm	Tapper, 12°
7	Width of Pellet Die	Drg. No.	222 mm	Step length 30 mm
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 mm / 12 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		840 mm	Tapping of Hole. 12° Back Side
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 mm	Tapping Depth 18.6 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/12/24

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		None - 1 Hole Closed

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

Counter - 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 mm 5.0 mm	4.5 mm	All Rows	20 mm				
3	External Relief Depth		5.0 mm	All Rows	10 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		25	12	24				

Inspected By (Sign) & Date

Ravi 25/12/24

Satyan 25/12/24

Reviewed by (Engineer-CNC)

Manager-QA