



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.		13751	38/66
2	Machined By		N.T.L. N/C Shop	Dr. No. 128.2.309
3	Pallet Die No.		13998 (10.0) mm	Row 03
4	Die Category	Drg. No.	M. Jombu	
5	Out Side Diameter	Drg. No.	680.7 mm ✓ Step OD = 692.8 mm	Tabber 3"
6	Inside Diameter	Drg. No.	546.12 mm (Bore 548.3 mm)	Side length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm / 32 x 7 x 9.2 mm (4 x 2) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 3 mm
10	Drilling Area Surface Smoothness		ok	Back Bore Side
11	Tapping Operator		N/C Shop	Tapping No. of Holes 2
12	Tapping PCD		619 mm	Back Side
13	Tapping Hole Diameter		N/C Check by N/C Bell	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Dept. 33.2 mm	Tapping Dept. 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 31/7/13	
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				Counter 60°
1	Counter Sinking Depth & Finish	ok		Row 8
2	External Relief Dia	110 mm	All Rows	
3	External Relief Depth		28 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		8 / 1 / 25	
Inspected By (Sign) & Date			Ravi 31/7/13	

Reviewed by (Engineer-CNC)

Manager-QA