



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.		13856	55/70
2	Machined By		V.T.L. M/c Shop	Drg No. 13.0 = 377
3	Pallet Die No.		13351 (8.0) M/c	Rev 203
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 M/c, Step 00. 697.8 M/c	Tapper = 5
6	Inside Diameter	Drg. No.	546.12 M/c (Reor = 548.3 M/c)	Step length = 28.5
7	Width of Pellet Die	Drg. No.	215 M/c	Under cot = 1.8 M/c
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 9.1 M/c (29.5 x 10 x 9.1 M/c) (6 x 8) M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	1 M/c Deep
11	Tapping Operator		M/c Shop	Both Side
12	Tapping PCD		618 M/c	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 = 32.2 M/c	Tapping Depth = 20.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/1/25

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
2	External Relief Dia	9.0 M/c	All Rows					Row = 12
3	External Relief Depth		15 M/c					
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	1	25			

Inspected By (Sign) & Date

Ravi 16/1/25

Reviewed by (Engineer-CNC)

Manager-QA