



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)

6005

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9903 to 10184	33/66
2	Machined By		V.T.L. H/C Shop	Drg No. 1.50.2.809
3	Pallet Die No.		10750 (6.0) H/C	Revol
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H/C Step 00. 693 H/C Step length 31 H/C	30.8 H/C
6	Inside Diameter	Drg. No.	548.12 H/C	Tapper 8°
7	Width of Pellet Die	Drg. No.	195 H/C	Under cut ~ 2.5 H/C
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/C 32 x 7 x 8 H/C	(4 x 8) H/C
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step 2 H/C
10	Drilling Area Surface Smoothness		OK	Deep Both Side
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 H/C	Tapping No. of Holes: 4
13	Tapping Hole Diameter		MIG Check by MIG Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.4 H/C	Tapping Depth 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/8/23

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

Counters 30°

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	7.5 H/C	7.5 H/C	All Lines						
3	External Relief Depth			33 H/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			28	8	23				

Inspected By (Sign) & Date

Ravi 28/8/23

Reviewed by (Engineer-CNC)

Manager-QA