



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.		13508 ✓	80/65.5 ✓
2	Machined By		V.T.L. H/c Shop	Drg no = 1802902
3	Pallet Die No.		14079 (1st.0) H/H	Rev = 03
4	Die Category	Drg. No.	58970	
5	Out Side Diameter	Drg. No.	639.6 H/H, Step 00, 659.2 H/H	Tabber 28°
6	Inside Diameter	Drg. No.	508.8 H/H, C10 Step = 593.3/599.5	Step length = 33 H/H
7	Width of Pellet Die	Drg. No.	175.1 H/H	
8	Grooves as per Drawing	Drg. No.	9x25 H/H, 30x21x7.25 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Slot 0.5 H/H Dash Bolt Side
11	Tapping Operator		H/c Shop	
12	Tapping PCD		574 H/H	Tapping No of Holes 4
13	Tapping Hole Diameter		MIG - Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one. Side Tapping and	Ind Side 4 Slot
15	Tapping Hole Depth		Drill Depth = 30.2 H/H	Tapping Depth = 28.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24/1/25

1	As per programme no.			4 slot
2	Gun Drilling Work Completed On			51.5 Long
3	Hole Finish In Gun Drilling	Marked	ok	28.1 H/H wide
4	Defective Holes (If Any)		No	15 H/H Deep

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

1	Counter Sinking Depth & Finish	ok					Counter = 60°
2	External Relief Dia	12.5 H/H	All Rows				Rep = 5
3	External Relief Depth		5.5 H/H				
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		24	1	25		

Inspected By (Sign) & Date

Ravi 24/1/25

Reviewed by (Engineer-CNC)

Manager-QA