



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10157	33/66
2	Machined By		V.T.L. H/c Shop	Drg No. L.S.O. 609
3	Pallet Die No.		10758 (G.O) NN	Revised
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 mm Step OD, 692.9 mm Tapper	8
6	Inside Diameter	Drg. No.	548.12 mm	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut 2.5 mm
8	Grooves as per Drawing	Drg. No.	32x7x8 mm 32x7x8 mm (4x8) mm	Step 3 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side
10	Drilling Area Surface Smoothness		OK	Deep Back side
11	Tapping Operator		H/c Shop	Tapping No of Holes, 4 Both Side
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 33.4 mm	Tapping Depth = 31.7 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 7/1/22	
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	7.5 mm	7.5 mm All Lines	Revised
3	External Relief Depth		33 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		7 9 23	
Inspected By (Sign) & Date			Ravi 7/1/22	

Reviewed by (Engineer-CNC)

Manager-QA