



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.		10157	33/66
2	Machined By		N.T.L. N/C Shop	Drg No. 18.02.09
3	Pallet Die No.		10759 (6.0)mm	Rev 2.01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 mm Step 002 692.8mm	Step length 31mm
6	Inside Diameter	Drg. No.	548.12 mm	Tappers 80° - 30.8°
7	Width of Pellet Die	Drg. No.	194.8 mm	Under cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8mm (11.5)mm	Step 2mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Back Side
10	Drilling Area Surface Smoothness		OK	Drill Both Side
11	Tapping Operator		N/C Shop	
12	Tapping PCD		619 mm	Tapping No. of Holes - 4
13	Tapping Hole Diameter		N16 Check by N16 Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.4mm Tapping Depth 31.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 8/9/23

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

1	Counter Sinking Depth & Finish	OK						Counter 30° Rev 12
2	External Relief Dia	7.5mm	7.5mm All Lines					
3	External Relief Depth		33mm					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Permare					
6	Material Sent For Hardening On Date		8	9	23			

Inspected By (Sign) & Date

Ravi 8/9/23

Reviewed by (Engineer-CNC)

Manager-QA