

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9520

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.		14523	98/26
2	Machined By		V.T.L. N/C Shop	Dry H. 12.7-330
3	Pallet Die No.		14018 (B.O) N/C	Revised
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm Step 00, 693 mm	Tabber 8°
6	Inside Diameter	Drg. No.	540.12 mm (Box: 548.1 mm)	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut: 2.8 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 mm / 32 x 7 x 9.1 mm (4 x 8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	8 mm Deep Bottom Side
11	Tapping Operator		N/C Shop	
12	Tapping PCD		619 mm	Tapping H. of hole: 2
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 33.2 mm	Tapping Depth: 31.6 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sasi 2/4/25

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

Counter = 30
Row = 12

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	7.0 mm		All Rows			
3	External Relief Depth			38 mm			
4	Inspection Done Before Hardening By (Name)			Sasi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date			2	4	25	

Inspected By (Sign) & Date

Sasi 2/4/25

Reviewed by (Engineer-CNC)

Manager-QA