

1011



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		15177	40/70
2	Machined By		N.T.L. N/C Shop	Drg. H. 12.0. 977
3	Pallet Die No.		14341 (6.0) mm	Rev. 103
4	Die Category	Drg. No.	M. 30 mm 60	
5	Out Side Diameter	Drg. No.	688 mm, Step 00. 697.7 mm	Tappet. 5°
6	Inside Diameter	Drg. No.	546.12 mm (Bor. 548.4 mm)	Step length 38.5
7	Width of Pellet Die	Drg. No.	215 mm	Under cut 1.75 mm
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 9.1 mm 29.5 x 10 x 9.1 mm (Bor. 8)	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	1 mm Deep
11	Tapping Operator		N/C Shop	Back Side
12	Tapping PCD		618 mm	Tapping H.
13	Tapping Hole Diameter		M16 Check by M16 B-12	of H. 12.0. 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Back Side
15	Tapping Hole Depth		Drill Depth. 32.4 mm	Tapping Depth. 30.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Res: 18/6/25

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

1	Counter Sinking Depth & Finish	OK						Res: 18/6/25
2	External Relief Dia	7.0 mm	All Rows					
3	External Relief Depth		30 mm					
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		18	6	25			

Inspected By (Sign) & Date

Res: 18/6/25

Reviewed by (Engineer-CNC)

Manager-QA