

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.		16000	35/40/66
2	Machined By		V.T.I. M/c Shop	88/66
3	Pallet Die No.		15751 (6.0) 44	Qty No. 1.2230
4	Die Category	Drg. No.	M. Jumbo	Reverse
5	Out Side Diameter	Drg. No.	680.144	Step OD = 693.44 Tapper 3"
6	Inside Diameter	Drg. No.	546.144 (Dor = 548.2) 44	Step length = 31mm
7	Width of Pellet Die	Drg. No.	195 44	Under cut = 2.8mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 44 (32 x 2 x 9.1 44 (4 x 8)	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Side
10	Drilling Area Surface Smoothness		OK	2nd Deep Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		619 44	of Hole 22
13	Tapping Hole Diameter		H16 = Check by H16 G. 1	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 33.4 44	Tapping depth 31.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 22/9/25

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

1	Counter Sinking Depth & Finish	OK						Counter = 30
2	External Relief Dia	6.5 44 / 7.0 44	Let Pad	6.5 44 / 7.0 44	7.0 44 / 7.0 44	7.0 44 / 7.0 44	7.0 44 / 7.0 44	Row 2 = 12
3	External Relief Depth		7.0 44 / 7.0 44	7.0 44 / 7.0 44	7.0 44 / 7.0 44	7.0 44 / 7.0 44	7.0 44 / 7.0 44	
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		22	9	25			
Inspected By (Sign) & Date			Ravi					

Reviewed by (Engineer-CNC)

Manager-QA