

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.			
2	Machined By		16031	33/66
3	Pallet Die No.		V.T.I. H/c Shop	Dry No 12d-609
4	Die Category	Drg. No.	15163 (6.0) mm	(Rev-03)
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.7 mm	Step 02. 692.9 mm, Tapped
7	Width of Pellet Die	Drg. No.	546.14 mm (Bore 548.4) mm	Step length 31
8	Grooves as per Drawing	Drg. No.	195 mm	End cut 9.5
9	Fitting Sizes on CNC Plate	Drg. No.	32x7x9.2 mm 32x7x9.2 mm	(4x8) mm
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		H/c Shop	9 mm Deep Bore
12	Tapping PCD		618.9 mm	Tapping No
13	Tapping Hole Diameter		H16: Check by H16 B-11	of Holes - 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill depth = 33.4 mm	Tapping depth 31
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi

16/9/25

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

Counter-30

1	Counter Sinking Depth & Finish	OK						Row-12
2	External Relief Dia	1.5 mm		All Rows				
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			16	9	25		
Inspected By (Sign) & Date				Ravi		16/9/25		

Reviewed by (Engineer-CNC)

Manager-QA