

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.		16294	35/40/66
2	Machined By		V.T.I. M/c Shop	Dry No. 18.0.300
3	Pallet Die No.		18473 (6.0)	Rev. 08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1	Step 0D = 692.8mm Tapping
6	Inside Diameter	Drg. No.	546.14mm (8.0 = 548.2)	Step length = 31mm
7	Width of Pellet Die	Drg. No.	195mm	12den cut = 2.8mm
8	Grooves as per Drawing	Drg. No.	32.7 = 9.1mm / 32.7 = 9.1mm	(4+8)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Fore Side Step
10	Drilling Area Surface Smoothness		OK	(2mm Deep Round side)
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		619mm	of Holes = 2
13	Tapping Hole Diameter		H16 = Check by H16 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 33.4mm	Tapping depth = 31mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi

15/10/25

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	6.5mm / 1.0mm	6.5mm	All Rows = 31mm				Row 212
3	External Relief Depth		1.0mm	All Rows = 28mm				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date			15	10	25		

Inspected By (Sign) & Date

Ravi

15/10/25

Reviewed by (Engineer-CNC)

Manager-QA