



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)

6325

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10058	35/63/78
2	Machined By		N.T.L. N/C Shop	Drg No. I.S.O. 298
3	Pallet Die No.		10897 (6.0)mm	Rev 2.01
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	836mm	Step 00: 638mm / 630.5mm / 543mm
6	Inside Diameter	Drg. No.	480.1mm / 489.1mm / 500.1mm	Step length: 28mm / 16.5mm
7	Width of Pellet Die	Drg. No.	182mm	
8	Grooves as per Drawing	Drg. No.	27x12x8x9.5mm / 37x12x8x9.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	[Tapping No. of holes: 4]
12	Tapping PCD		540mm	
13	Tapping Hole Diameter		N/C Check by N/C Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 2nd Side One Side	
15	Tapping Hole Depth		Drill Depth: 28.4mm Tapping Depth: 28.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 26/10/23	[1 Slot]
1	As per programme no.		_____	[28.1mm width] [17mm Depth]
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		Rev 2.10
2	External Relief Dia	6.5mm / 7.0mm	6.5mm All Lines / 7.0mm All Lines	
3	External Relief Depth		43mm / 15mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		26 / 10 / 23	
Inspected By (Sign) & Date			Ravi 26/10/23	

Reviewed by (Engineer-CNC) *Satyam* 26/10/23

Manager-QA