



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9645 to 9823	30/50/66
2	Machined By		V.T.L H/c Shop	Drg No. 1-S.O. 209
3	Pallet Die No.		10956 (6.0) H	Rev 201
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 mm	Step 00 = 699 mm
6	Inside Diameter	Drg. No.	548.12 mm	Tapbers 8°
7	Width of Pellet Die	Drg. No.	195 mm	Step length = 31 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 mm / 32 x 7 x 8 mm (4 x 8) mm	Under cut = 2.5 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Face Side Step 2 mm [Deep Both side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	[Tapping No of Holes = 4 Both Side
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16: Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 33.3 mm	Tapping Depth = 31.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 28/6/23	
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 mm / 7.0 mm	6.5 mm All Lines	7.0 mm All Lines
3	External Relief Depth		36 mm	16 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		28	6 23
Inspected By (Sign) & Date			Ravi 28/6/23	

Reviewed by (Engineer-CNC)

Manager-QA