



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)

6432

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10553 ✓	35/45/66 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. 1.3.0.609
3	Pallet Die No.		11186 (6.0) n/c	Recess ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 n/c Step OD 693 n/c	Tappes = 8°
6	Inside Diameter	Drg. No.	548.14 n/c	Step length 2 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c 32 x 7 x 8.1 n/c	Face Side Step 3 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Drill Both side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No
12	Tapping PCD		619 n/c	of holes = 4
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4 n/c	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/11/23

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

Counter = 30°

1	Counter Sinking Depth & Finish	ok							Ravi 12
2	External Relief Dia	6.5 n/c 7.0 n/c	6.5 n/c	All Cines	7.0 n/c	All Cines			
3	External Relief Depth			31 n/c		21 n/c			
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	11	23			

Inspected By (Sign) & Date

Ravi 16/11/23

Satyam 16/11/23

Reviewed by (Engineer-CNC)

Manager-QA