



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.		9792	33/53/70
2	Machined By		V.T.L n/c Shop	Drg No. 28.02 377
3	Pallet Die No.		10579 (6.0) mm	Rev=03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 mm	Step OD = 697.7 mm Tapper = 5°
6	Inside Diameter	Drg. No.	548.14 mm	Step length = 38.5
7	Width of Pellet Die	Drg. No.	215 mm	Udencut = 1.8 mm
8	Grooves as per Drawing	Drg. No.	29.5x10x8.1 mm 29.5x10x8.1 mm	(6x8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side step 1 mm Dark Both side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		618 mm	
13	Tapping Hole Diameter		NIS → Check by NIS Bolt	Tapping No. of Holes = 2 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 32.3 mm Tapping Depth = 30.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rao: 29/6/23

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 / 7.3 mm	6.5 mm	All Lines	7.3 mm	All Lines	Row = 4
3	External Relief Depth		37 mm		17 mm		
4	Inspection Done Before Hardening By (Name)						Rao!
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		29	8	29		

Inspected By (Sign) & Date

Rao: 29/6/23

Reviewed by (Engineer-CNC)

Manager-QA