



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.		10892	30/40/66
2	Machined By		V.T.L. N/C Shop	28/38/66
3	Pallet Die No.		11182 (6.0) H/H	Drg No. 1.8.0-2609 Rev. 01
4	Die Category	Drg. No.	H. Jumbo	4x3
5	Out Side Diameter	Drg. No.	680.69 H/H	Step OD = 693 H/H
6	Inside Diameter	Drg. No.	548.12 H/H	Tapper = 8° Step length = 31 H/H
7	Width of Pellet Die	Drg. No.	195 H/H	Under cut = 2.5 H/H
8	Grooves as per Drawing	Drg. No.	32x7x8 H/H 32x7x8 H/H (4x8 H/H)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 H/H Back Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No of Holes = 4
12	Tapping PCD		619 H/H	Both Side
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 = 33.4 H/H	Tapping Depth = 31.7 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/12/23

- As per programme no.
- Gun Drilling Work Completed On
- Hole Finish In Gun Drilling
- Defective Holes (If Any)

Marked

ok

No

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Count = 30°

1	Counter Sinking Depth & Finish	ok	1st Pad	2nd Pad				
2	External Relief Dia	6.5 H/H 7.0 H/H	6.5 H/H All Rows	6.5 H/H All Rows	38 H/H			
3	External Relief Depth		36 H/H	7.0 H/H All Rows	26 H/H	7.0 H/H All Rows	38 H/H	
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		13	12	23			

Inspected By (Sign) & Date

Ravi 13/12/23

Suh 13/12/23

Reviewed by (Engineer-CNC)

Manager-QA