



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

5790

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9835	53/69
2	Machined By		V.T.L. n/c Shop	Drg No. 1-S.D. 111
3	Pallet Die No.		10375 (3.8) n/c	Rev. 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 n/c, Step 002 791.6 n/c	Step length 29.4
6	Inside Diameter	Drg. No.	660.12 n/c	Under cut 2.6 n/c
7	Width of Pellet Die	Drg. No.	323.8 n/c	
8	Grooves as per Drawing	Drg. No.	21.4 x 8 x 8 n/c 21.4 x 8 x 8 n/c	
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 = 12 Both side
12	Tapping PCD		725 n/c	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 31.4 n/c	Tapping Depth 29.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raj: 4/7/23

1	As per programme no.			2 slot 32.1 n/c width 8 n/c Deep Both side
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							Raj: 4/7/23
2	External Relief Dia	4.3 n/c	outside (3-3)		Inner				
3	External Relief Depth		14 n/c		7 n/c				
4	Inspection Done Before Hardening By (Name)								Raj:
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			4	7	23			

Inspected By (Sign) & Date

Raj: 4/7/23

Reviewed by (Engineer-CNC)

Manager-QA