



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)

6861

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11118	28/48/66
2	Machined By		N.T.L. H/c Shop	Drg. No. 1.3.0. 609
3	Pallet Die No.		11483 (G.O) H/c	Rev. 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H/c	Step 00-698.7 H/c Tapper 8°
6	Inside Diameter	Drg. No.	548.12 H/c	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Undercut 2.4 H/c
8	Grooves as per Drawing	Drg. No.	32x7x8 H/c 32x7x8 H/c (4x8) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 8 H/c
10	Drilling Area Surface Smoothness		ok	Deep Back Side
11	Tapping Operator		H/c Shop	Tapping No. of Holes: 4
12	Tapping PCD		619 H/c	Back 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/c	Tapping Depth 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/1/24

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

Counters 30°

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	6.5 H/c 7.0 H/c	6.5 H/c All Rows	7.0 H/c All Rows				
3	External Relief Depth		38 H/c	18 H/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		29	1	24			

Inspected By (Sign) & Date

Ravi 29/1/24

Reviewed by (Engineer-CNC)

Manager-QA