



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.		11317	45/60
2	Machined By		N.T.L. M/C Shop	Drg No. (S.O) 584
3	Pallet Die No.		11884 (200) M/C	Rev 01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 M/C	
6	Inside Diameter	Drg. No.	Step 00, 798 M/C	Tapper = 4°
7	Width of Pellet Die	Drg. No.	660.12 M/C	Step length = 25.5
8	Grooves as per Drawing	Drg. No.	324 M/C	Under cot, 9 M/C
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 10 M/C / 21.5 x 8 x 10 M/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		725 M/C	Tapping No. of holes = 12 Both Side
13	Tapping Hole Diameter		M20 - Check by M2 - Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 31 M/C	Tapping Depth = 28.4 M/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raoi 11/3/24

1	As per programme no.			2 slot 32.1 M/C width 8 M/C Depth 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					Counter = 60° Raoi 27
2	External Relief Dia	8.5 M/C	outside (3-3)	1 mm			
3	External Relief Depth		23 M/C	15 M/C			
4	Inspection Done Before Hardening By (Name)						Raoi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		1	3	24		
Inspected By (Sign) & Date							Raoi 11/3/24

Reviewed by (Engineer-CNC)

Manager-QA