



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.		11426	30/4/66
2	Machined By		V.T.L H/c Shop	33/43/66
3	Pallet Die No.		11925 (6.0) H/c	Dy H/c 1.8.0.609
4	Die Category	Drg. No.	H. Jumbo	Revol
5	Out Side Diameter	Drg. No.	680.69 H/c	Step OD = 693 H/c
6	Inside Diameter	Drg. No.	548.12 H/c	Tabber = 8
7	Width of Pellet Die	Drg. No.	195 H/c	Step length 3 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/c	Under cut 2.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 8 H/c	(4 x 8) H/c
10	Drilling Area Surface Smoothness		ok	Face side step H/c
11	Tapping Operator		H/c Shop	Back both side
12	Tapping PCD		619 H/c	Tapping No of holes = 4
13	Tapping Hole Diameter		H16 = Check by H16 Ball	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 34 H/c	Tapping Depth = 31.8 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 2/3/24

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 20

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	6.5 H/c 7.0 H/c	6.5 H/c 7.0 H/c	6.5 H/c 7.0 H/c	6.5 H/c 7.0 H/c					
3	External Relief Depth	35 H/c 26 H/c	35 H/c 26 H/c	33 H/c 25 H/c	33 H/c 25 H/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date

Ravi 2/3/24

Reviewed by (Engineer-CNC)

Manager-QA