



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.		11419	45/45
2	Machined By		V.T.L. M/C Shop	Dy. No. L.S.O. 290
3	Pallet Die No.		11737 (3.0) M/C	Rev. No.
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	690mm, Step OD, 703mm	Tabbers 6°
6	Inside Diameter	Drg. No.	600.12 mm	Step length 23.5
7	Width of Pellet Die	Drg. No.	250mm	Undercut 6.5mm
8	Grooves as per Drawing	Drg. No.	24x5x9mm 24x5x9mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Tapping of holes 12 Bottom Side
12	Tapping PCD		655mm	
13	Tapping Hole Diameter		M16 2 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 25mm Tapping Depth 23mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date *Ravi 7/3/24*

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

1	Counter Sinking Depth & Finish	<i>3.5mm</i>	<i>4mm</i>					Counter 60° Ravi 41
2	External Relief Dia	<i>3.5mm</i>	<i>Outside (3-3)</i>		Inner			
3	External Relief Depth		<i>4mm</i>		Mill			
4	Inspection Done Before Hardening By (Name)							<i>Ravi</i>
5	Material Sent For Hardening By (Name)							<i>Lark Furnace</i>
6	Material Sent For Hardening On Date			<i>7</i>	<i>3</i>	<i>24</i>		
Inspected By (Sign) & Date								<i>Ravi 7/3/24</i>

Satyam
7/3/24
Reviewed by (Engineer-CNC)

Manager-QA