



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.		11322/	28/38/66/
2	Machined By		N. T. G. n/c Shop	Digital L.S. 0.2609
3	Pallet Die No.		11922 (6.0) n/c	Rev. of
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7mm Step 002-893 n/c	Tapper 8°
6	Inside Diameter	Drg. No.	548.14mm	Step length 31mm
7	Width of Pellet Die	Drg. No.	195mm	Under cut 2.5mm
8	Grooves as per Drawing	Drg. No.	32x7x8mm 32x7x8mm	(4x8)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step 8mm
10	Drilling Area Surface Smoothness		ok	Deep Botu Side
11	Tapping Operator		n/c Shop	Tapping No
12	Tapping PCD		619mm	of Holes, 4
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	Botu Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.8mm	Tapping Depth 31.7mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/3/24

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	ok					Counter 30°
2	External Relief Dia	8.5mm 7.0mm	6.5mm All Rows	7.0mm All Rows			Row 12
3	External Relief Depth		38mm	98mm			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		16	3	24		

Inspected By (Sign) & Date

Ravi 16/3/24

Satish 16/3/24

Reviewed by (Engineer-CNC)

Manager-QA