



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.		11617	28/38/66
2	Machined By		N.T.L. H/C Shop	Drg. No. 103.02.609
3	Pallet Die No.		11920 (6.0) H/C	Rev. 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/C, Step OD: 693 H/C	Tapker: 8°
6	Inside Diameter	Drg. No.	548.1 H/C	Step length: 31 H/C
7	Width of Pellet Die	Drg. No.	194.8 H/C (D)	Under cut: 2.5 H/C
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/C 32 x 7 x 8 H/C	(4 x 8) H/C
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step 2 H/C
10	Drilling Area Surface Smoothness		OK	Deep Both Side
11	Tapping Operator		H/C Shop	Tapping No. of Holes: 4
12	Tapping PCD		619 H/C	Both 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: 33.8 H/C	Tapping Depth: 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Lavi: 28/3/24	
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 Rows: 12
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 38 H/C	
4	Inspection Done Before Hardening By (Name)		Lavi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		28/3/24	
Inspected By (Sign) & Date			Lavi: 28/3/24	

Reviewed by (Engineer-CNC)

Manager-QA