



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)

7261

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11647	45/55
2	Machined By		N.T.L. n/c Shop	Drg No. 1.3.02-639
3	Pallet Die No.		11948 (8.0) n/c	Review
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	630mm, Step OD = 624mm, Tapper = 12	
6	Inside Diameter	Drg. No.	520.12mm	Step length = 18mm
7	Width of Pellet Die	Drg. No.	272mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Ho of holes 12 Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.7mm Tapping Depth = 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 5/4/24

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 = 60° Rov = 18
2	External Relief Dia	8.5mm	Outside (2.3)	Inner				
3	External Relief Depth		18mm	10mm				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		5	4	24			
Inspected By (Sign) & Date		Ravi 5/4/24						

Reviewed by (Engineer-CNC)
Ravi 5/4/24

Manager-QA