



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.		11653	33/53/66
2	Machined By		V.T.L H/c Shop	Dry Hole 1.2.0. 609
3	Pallet Die No.		12246(G.O) H/c	Recess
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7mm Step 0.692	8mm Tapper 8"
6	Inside Diameter	Drg. No.	548.14mm	Step length 3mm
7	Width of Pellet Die	Drg. No.	195mm	Under cut 2.4mm
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x8mm (4x8)mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step 2mm
10	Drilling Area Surface Smoothness		ok	Dark Red Side
11	Tapping Operator		H/c Shop	Tapping No
12	Tapping PCD		619mm	of Hole 4
13	Tapping Hole Diameter		M16, Check by M16 Bolt	Bolt Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.7mm	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 10/4/24	
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	Counters 230
2	External Relief Dia	6.5mm / 7.0mm	6.5mm All Rows	7.0mm All Rows
3	External Relief Depth		33mm	13mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		10 4 24	
Inspected By (Sign) & Date			Ravi 10/4/24	

Reviewed by (Engineer-CNC)

Manager-QA