

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.		12247	28/38/66 ✓
2	Machined By		V.T.L M/C Shop	Drg No- LSD 609
3	Pallet Die No.		12798 (6.0mm)	(Revol)
4	Die Category	Drg. No.	M. Jumbo 3200Vc-4X3mm	✓
5	Out Side Diameter	Drg. No.	680.7mm	Step Length-31mm
6	Inside Diameter	Drg. No.	548.12mm	Taper-8° ✓
7	Width of Pellet Die	Drg. No.	195mm	Undercut-2.5mm
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8mm / 32 X 7 X 7.8mm	4 X 8mm
9	Fitting Sizes on CNC Plate	Drg. No.	✓ OK	[Tapping No.] [of Holes 4] [Both side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Face side Step 2mm Deep Both side
12	Tapping PCD		619mm	
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-35mm Tapping Depth-	32.44
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 08/07/24

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

Counter - 30
Row - 12

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	6.5mm, 7.0mm	6.5mm		7.0mm		
3	External Relief Depth		38mm		28mm	All Rows	
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		08	07	24		

Inspected By (Sign) & Date

Ramanpreet Singh 08/07/24

Reviewed by (Engineer-CNC)

Manager-QA