



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.		12356	30/66, 28/66	
2	Machined By		V.T.L M/C Shop	Drg No-LSD 320	
3	Pallet Die No.		12794 (60mm)	(R05)	
4	Die Category	Drg. No.	M. Jumbo 22000-413mm		
5	Out Side Diameter	Drg. No.	680.8mm Stel of- 693.1mm	Stel length-31mm	
6	Inside Diameter	Drg. No.	548.1mm	Tapper- 8°	
7	Width of Pellet Die	Drg. No.	195mm	Under cut- 275mm	
8	Grooves as per Drawing	Drg. No.	32 X 7 X 18mm / 32 X 7 X 18mm	4 X 8mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 4]	
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		M/C Shop	Both Side	
12	Tapping PCD		619mm	Face Side Stel	
13	Tapping Hole Diameter		M16 check by M16 Bolt	2mm Deep Both	
14	Tapping On Second Side	Half pitch of 1st side	ok	Side	
15	Tapping Hole Depth		Drill Depth- 34mm Tapping Depth- 31.8mm		
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ramanpreet Singh 10/07/24		
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°)					
1	Counter Sinking Depth & Finish	ok		Row- 12	
2	External Relief Dia	7.0mm	1st Pad	2nd Pad	
3	External Relief Depth		36mm	38mm	
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		10	07	24
Inspected By (Sign) & Date			Ramanpreet Singh 10/07/24		

Signature
10/7/24

Reviewed by (Engineer-CNC)

Manager-QA