



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.		12353	42/66
2	Machined By		V.T.L M/C SHOP	Drg No- LSD 788
3	Pallet Die No.		12785 (6.0mm)	(Rev 01)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	678mm	Step of- 693mm
6	Inside Diameter	Drg. No.	548.12mm	Step Length- 38mm
7	Width of Pellet Die	Drg. No.	195mm	Under cut- 285mm
8	Grooves as per Drawing	Drg. No.	31x8x8mm / 31x8x8mm	Taper- 8°
9	Fitting Sizes on CNC Plate	Drg. No.	OK	4x8mm
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 2
11	Tapping Operator		M/C SHOP	Both side
12	Tapping PCD		619mm	Face side Step
13	Tapping Hole Diameter		M 16 check by M 16 Bolt	1mm Deep
14	Tapping On Second Side	Half pitch of 1st side	OK	Both side
15	Tapping Hole Depth		Drill Depth- 38.4mm	Tapping Depth- 36.5mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanpreet Singh 12/07/24	
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				
1	Counter Sinking Depth & Finish	OK		Counter- 30° Row-12
2	External Relief Dia	7.0mm	All Rows	
3	External Relief Depth		24mm	
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		12 07 24	
Inspected By (Sign) & Date			Ramanpreet Singh 12/07/24	

Satya 12/7/24

Reviewed by (Engineer-CNC)

Manager-QA