



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.		12408	45/66
2	Machined By		V.T.L M/C Shop	Drg No- LSP 320
3	Pallet Die No.		12795 (80mm)	(REV 05)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	68.0 mm	Step Length-31mm
6	Inside Diameter	Drg. No.	Step of- 69.1mm	31.3mm
7	Width of Pellet Die	Drg. No.	548.12mm	Taper-8°
8	Grooves as per Drawing	Drg. No.	195mm	Under cut-2.85mm
9	Fitting Sizes on CNC Plate	Drg. No.	32X7X8mm / 32X7X8mm	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 4
11	Tapping Operator		M/C Shop	
12	Tapping PCD		619mm	Both Side
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-34mm Tapping Depth-31.7mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 24/07/24

1	As per programme no.			Discuss with
2	Gun Drilling Work Completed On			Sales By.
3	Hole Finish In Gun Drilling	Marked	OK	Meeraj sir
4	Defective Holes (If Any)		No.	For Tapping Hole Issue - Set

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter-30°

1	Counter Sinking Depth & Finish	OK						Row-10
2	External Relief Dia	9.0mm	Add Rows					
3	External Relief Depth		21mm					
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		24	07	24			

Inspected By (Sign) & Date

Ramanjeet Singh 24/07/24

Sats 29/7/24

Reviewed by (Engineer-CNC)

Manager-QA