



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.		12387	26/88
2	Machined By		V.T.L Mic Shop	Dr. No - LSD 3ps
3	Pallet Die No.		19888 (60mm)	CREVol
4	Die Category	Drg. No.	M. Jumbo stock-413mm	
5	Out Side Diameter	Drg. No.	680.1mm	Step length-31mm
6	Inside Diameter	Drg. No.	548.12mm	Tapper-8
7	Width of Pellet Die	Drg. No.	195mm	Undercut-230mm
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x8mm	4x8mm
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		Mic Shop	
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M16 check by M16 Bolt	Face Side Step 2mm
14	Tapping On Second Side	Half pitch of 1st side	OK	Deep Both Side
15	Tapping Hole Depth		Drill Depth - 34mm	Tapping Depth - 31.6mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanjeet Singh 30/07/24	
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		40mm	
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		30 07 24	
Inspected By (Sign) & Date			Ramanjeet Singh 30/07/24	

Sats 30/7/24

Reviewed by (Engineer-CNC)

Manager-QA