



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.		18424 ✓	32/50
2	Machined By		V.T.L M/c Shop	Drg No- LSD 932
3	Pallet Die No.		12956 (28mm)	(REV 00)
4	Die Category	Drg. No.	Jumbo	✓
5	Out Side Diameter	Drg. No.	760mm, Step od- 801	Step length- 26mm
6	Inside Diameter	Drg. No.	660/19mm	Taper- 7.5mm
7	Width of Pellet Die	Drg. No.	316mm	Undercut- 20.5mm
8	Grooves as per Drawing	Drg. No.	18X 9X 6mm / 18X 9X 6mm	✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 12 Both Side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth- 22.4mm Tapping Depth- 20.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 02/08/24

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 2 Hole close	

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

Counter- 60°

1	Counter Sinking Depth & Finish	OK						Row-59
2	External Relief Dia	3.3mm	outside (3-3)	Inner				
3	External Relief Depth		25mm	18mm				
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		02	08	24			

Inspected By (Sign) & Date

Ramanpreet Singh 02/08/24

Saty 21/8/24

Reviewed by (Engineer-CNC)

Manager-QA