



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.		11878 ✓	40/40
2	Machined By		V.T.L M/c Shop	Dwg No - LSD 1039
3	Pallet Die No.		11779 (5.0mm) ✓	(Rev00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	610mm ✓	Step OD - 682mm, Step Length - 27mm, 18mm
6	Inside Diameter	Drg. No.	530.12mm ✓	596mm Under cut - 36mm ✓
7	Width of Pellet Die	Drg. No.	278mm ✓	
8	Grooves as per Drawing	Drg. No.	43 x 8 x 8mm / 27 x 8 x 8mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 8]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		594mm ✓	
13	Tapping Hole Diameter		M16 check by M16 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	1 Side Tapping & 2 nd Side 1 Slot ✓	
15	Tapping Hole Depth		Drill Depth - 25.4mm Tapping Depth - 23.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK	Maintain After Hard.
Inspected By (Sign) & Date		Ramanpreet Singh 06/8/24		<u>A. Jeyaraj</u>
1	As per programme no.		—	1 Slot 28mm
2	Gun Drilling Work Completed On		—	Width 18mm
3	Hole Finish In Gun Drilling	Marked	OK	Deep ✓
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/missed holes with the help of Permanent Marker Counter - 60°				
1	Counter Sinking Depth & Finish		OK	Row - 28
2	External Relief Dia		5.5mm ✓	outside 3-3 Inner
3	External Relief Depth		5mm ✓	0
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		06 08 24	
Inspected By (Sign) & Date		Ramanpreet Singh 06/08/24		

Reviewed by (Engineer-CNC)

Manager-QA