



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.		11879	32/32
2	Machined By		VTL M/C Shop	Drg No - LSD 1044
3	Pallet Die No.		11780 (3.0mm)	(REV 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	594mm	Step length - 27mm/17.5mm
6	Inside Diameter	Drg. No.	63.12mm	Undercut - 47mm
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	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 8]
11	Tapping Operator		M/C Shop	[Side]
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 & 2nd 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	

Inspected By (Sign) & Date

Ramanjeet Singh 06/08/24

Maintain After Hard.

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 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 - 41
2	External Relief Dia	3.5mm	Outside (3-3)	Inner				
3	External Relief Depth		3mm	0				
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		06	08	24			

Inspected By (Sign) & Date

Ramanjeet Singh 06/08/24

Reviewed by (Engineer-CNC)

Manager-QA