



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.		1P446	25/35/55
2	Machined By		V.T.L M/c Shop	Drg No- LSP340
3	Pallet Die No.		1P502 (6.0mm)	(REV00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	690 mm	Step 00 - 682 mm
6	Inside Diameter	Drg. No.	580.1 mm	Step Length - 34.5 mm
7	Width of Pellet Die	Drg. No.	266 mm	Tap 12°
8	Grooves as per Drawing	Drg. No.	28.5 x 6 x 12 mm / 28.5 x 6 x 12 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 12 Both Side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		630 mm	
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 - 25.4 mm	Tapping Depth - 23.5 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 08/08/24

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

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

Counter - 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm	All Rows				
3	External Relief Depth		30mm	20mm					
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		08	08	24				

Inspected By (Sign) & Date

Ramanjeet Singh 08/08/24

Reviewed by (Engineer-CNC)

Manager-QA