



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.		12508	49/15
2	Machined By		VTL MLC Shop	Drg No - LSP 693
3	Pallet Die No.		11765 (3.8mm)	(Rev 00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	829.8 μ \pm Step 00, 822.8 μ	Stel length - 33mm / 33.
6	Inside Diameter	Drg. No.	750.12 μ \pm	Tappers 4°
7	Width of Pellet Die	Drg. No.	324mm	
8	Grooves as per Drawing	Drg. No.	30 X 8 X 8.5mm / 30 X 8 X 8.5mm	
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		MLC Shop	
12	Tapping PCD		760mm	
13	Tapping Hole Diameter		M 22 Check by M 22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 36.4 μ Tapping Depth - 39.5 μ	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet 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 2 Hole Close

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	4.3mm	outside (3-3)	Inner			
3	External Relief Depth		31mm	23mm			
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		08	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 08/08/24

Signature

Reviewed by (Engineer-CNC)

Manager-QA