

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.		12470	28/32/66
2	Machined By		V.T.L M/c Shop	Dwg No - LSP 607
3	Pallet Die No.		19889 (6.0mm)	(REV 01)
4	Die Category	Drg. No.	M-Jumbo groove-4X3mm	
5	Out Side Diameter	Drg. No.	680.7mm	Step Length - 31mm / 31.3mm
6	Inside Diameter	Drg. No.	548.12mm	Taper - 8°
7	Width of Pellet Die	Drg. No.	195mm	Under cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8 mm / 32 X 7 X 8 mm	4 X 8
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of]
10	Drilling Area Surface Smoothness		OK	Holes 4
11	Tapping Operator		M/c Shop	[Both Side]
12	Tapping PCD		619mm	Face Side Step
13	Tapping Hole Diameter		M16 check by M16 Bolt	2mm Deep Both
14	Tapping On Second Side	Half pitch of 1st side	OK	Side.
15	Tapping Hole Depth		Drill Depth - 34mm	Tapping Depth - 31.6mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 09/08/24

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 - 30°

1	Counter Sinking Depth & Finish	OK						Row - 12
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm	ALL Rows			
3	External Relief Depth		38mm	28mm				
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		09	08	24			

Inspected By (Sign) & Date

Ramanjeet Singh 09/08/24

Reviewed by (Engineer-CNC)

Manager-QA