

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.			
2	Machined By		VT-L M/c Shop	30/668 28/66
3	Pallet Die No.		12582	Drg No - LSP 802
4	Die Category	Drg. No.	12972 (6.0mm)	(Rev 00)
5	Out Side Diameter	Drg. No.	M-Jumbo	
6	Inside Diameter	Drg. No.	680mm	Step length - 32.5mm/33.7mm
7	Width of Pellet Die	Drg. No.	Step OD - 693mm	Taper - 5°
8	Grooves as per Drawing	Drg. No.	548mm	Undercut - 3.4mm
9	Fitting Sizes on CNC Plate	Drg. No.	195mm	
10	Drilling Area Surface Smoothness		26.5 x 10 x 8mm / 26.5 x 10 x 8mm	
11	Tapping Operator		OK	Tapping No. of Holes 2 Both Side
12	Tapping PCD		OK	
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 - 32.8mm Tapping Depth - 30.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 10/08/24

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

1	Counter Sinking Depth & Finish	OK						Counter - 30°
2	External Relief Dia	7.0mm	1st Pd	2nd Pd				Row - 12
3	External Relief Depth		36mm	38mm				
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		10	08	24			

Inspected By (Sign) & Date

Ramanpreet Singh 10/08/24

Satya Jolshay

Reviewed by (Engineer-CNC)

Manager-QA