



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

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		IP523	36/55
3	Pallet Die No.		V.T.L M/C Shop	Drg No - LSP 347
4	Die Category	Drg. No.	IP397 (6.0mm)	(REV 00)
5	Out Side Diameter	Drg. No.	SSEW	
6	Inside Diameter	Drg. No.	630mm	Step OD - 124mm
7	Width of Pellet Die	Drg. No.	570.2mm	Step Length - 18mm
8	Grooves as per Drawing	Drg. No.	222mm	Taper - 12°
9	Fitting Sizes on CNC Plate	Drg. No.	13 X 8 X 5mm / 13 X 8 X 5mm	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 12
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		565mm	Both Side
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.5mm Tapping Depth - 18.5mm	
17	Visual Inspection Before Gun Drilling		Yes	

Inspected By (Sign) & Date

Ramanpreet Singh 16/08/24

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	Outside (3-3)	Inner					
3	External Relief Depth		25mm	19mm					
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		16	08	24				

Inspected By (Sign) & Date

Ramanpreet Singh 16/08/24

Sony 16/8/24

Reviewed by (Engineer-CNC)

Manager-QA