



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.		12675 ✓	36/50 ✓
2	Machined By		V.T.L M/c Shop	Drg No- LSD 670
3	Pallet Die No.		13166 (30mm)	(REV00)
4	Die Category	Drg. No.	Jumbo ✓	
5	Out Side Diameter	Drg. No.	760 mm Step 00-803	Step length-30mm
6	Inside Diameter	Drg. No.	680.12 mm ✓	Tapper = 10°
7	Width of Pellet Die	Drg. No.	290mm ✓	Under cut = 0.4
8	Grooves as per Drawing	Drg. No.	27 X 8 X 7.5mm / 27 X 8 X 7.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 12 Both side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		724mm ✓	
13	Tapping Hole Diameter		M22 Check by M22 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 29.4 mm Tapping Depth - 27.5 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 25/08/24

1 As per programme no.

2 Gun Drilling Work Completed On

3 Hole Finish In Gun Drilling

Marked

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							Row-48
2	External Relief Dia	3.5mm	outside (3-3)	Inner					
3	External Relief Depth		20mm	14mm					
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		25	08	24				

Inspected By (Sign) & Date

Ramanpreet Singh 25/08/24

26/8/24

Reviewed by (Engineer-CNC)

Manager-QA