



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.		12473	33/48/70
2	Machined By		V.T.L M/C Shop	Part No - LSD 377
3	Pallet Die No.		12935 (6.0mm)	(REV 03)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 mm	Step length - 38.5mm
6	Inside Diameter	Drg. No.	548.12 mm	Tap angle - 5°
7	Width of Pellet Die	Drg. No.	215 mm	Under cut - 1.8mm
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 mm	(6 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 10 x 8 mm	[Tapping No. of Holes 2 Both Side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	[Face Side Step 1mm Deep Both Side]
12	Tapping PCD		618 mm	
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 - 2.4mm Tapping Depth - 20.4mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date *Ramanpreet Singh 24/08/24*

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 - 38 Row - 14

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	6.5mm, 7.3mm	6.5mm	7.3mm	All Rows	
3	External Relief Depth		37mm	PPmm		
4	Inspection Done Before Hardening By (Name)		<i>Ramanpreet Singh</i>			
5	Material Sent For Hardening By (Name)		<i>Lark Furnace</i>			
6	Material Sent For Hardening On Date		P4	08	P4	

Inspected By (Sign) & Date *Ramanpreet Singh 24/08/24*

Satish
 24/8/24
 Reviewed by (Engineer-CNC)

Manager-QA