

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	35/40/66
2	Machined By		V.T.L M/c Shop	Drg No - LSD 3P
3	Pallet Die No.		12944 (60mm)	(REV 01)
4	Die Category	Drg. No.	M Jumbo groove 4x3mm	
5	Out Side Diameter	Drg. No.	680.1mm	Step length - 31mm
6	Inside Diameter	Drg. No.	548.12mm	Taper - 8°
7	Width of Pellet Die	Drg. No.	195 mm	Under cut - 9.5mm
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x8mm	4x8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of]
10	Drilling Area Surface Smoothness		ok	[Holes 2]
11	Tapping Operator		M/c Shop	[Both Side]
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M16 check by M16 Bolt	face side step 2nd
14	Tapping On Second Side	Half pitch of 1st side	ok	Deep Both Side
15	Tapping Hole Depth		Drill Depth - 34.4mm	Tapping Depth - 31.8mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 27/08/24

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°
Row - 12

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5mm, 7.0mm	6.5mm		7.0mm		
3	External Relief Depth		31mm		26mm		
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		27	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 27/08/24

Reviewed by (Engineer-CNC)

Manager-QA