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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.		12796	66/66
2	Machined By		V.T.L M/c Shop	Drg No - LSD 609
3	Pallet Die No.		13280 (10.0mm)	(REV 01)
4	Die Category	Drg. No.	M. Jumbo 2200K-413mm	
5	Out Side Diameter	Drg. No.	680.1mm Step 01 - 693mm	Step length - 31mm
6	Inside Diameter	Drg. No.	548.12mm	Tapped - 8°
7	Width of Pellet Die	Drg. No.	195mm	Under cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8mm / 32 x 7 x 8mm	4 x 8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 4 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M 16 check by M 16 Bolt	Face Side Step
14	Tapping On Second Side	Half pitch of 1st side	ok	2mm Deep Both Side
15	Tapping Hole Depth		Drill Depth - 34mm Tapping Depth - 31.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 02/09/24

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 - 6° Row - 8

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	No Relief	—				
3	External Relief Depth		—				
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		02	09	24		

Inspected By (Sign) & Date

Ramanjeet Singh 02/09/24

Signature
21/9/24

Reviewed by (Engineer-CNC)

Manager-QA