



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8178

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.		12748	40/60/66
2	Machined By		V.T.L M/c Shop	Drg No - LSD 609
3	Pallet Die No.		12947 (60mm)	(Rev 02)
4	Die Category	Drg. No.	M. Jumbo	groove - 413mm
5	Out Side Diameter	Drg. No.	68.1mm	Step od - 69.3mm
6	Inside Diameter	Drg. No.	54.812mm	Step Length - 31mm
7	Width of Pellet Die	Drg. No.	19.5mm	Taper - 8°
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8mm / 32 X 7 X 8mm	Under Cut - 2.5mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	4 X 8mm
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes ? Both Side]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M16 check by M16 Bolt	Face Side Step 2mm
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

Ramanjeet Singh 10/09/24

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 - 30°

1	Counter Sinking Depth & Finish	ok							Row - 12
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm	All Rows				
3	External Relief Depth		26mm	6mm					
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		10	09	24				

Inspected By (Sign) & Date

Ramanjeet Singh 10/09/24

Sony 10/09/24

Reviewed by (Engineer-CNC)

Manager-QA