



Lark Engineering Company (India) Pvt. Ltd.

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

8177

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	Drx No - LSD 609
3	Pallet Die No.		12748 (6.0mm)	(Revop)
4	Die Category	Drg. No.	M. Jumbo 220V1-413mm	✓
5	Out Side Diameter	Drg. No.	680.1mm	Step length - 31mm
6	Inside Diameter	Drg. No.	548.12mm	Tapper - 8°
7	Width of Pellet Die	Drg. No.	195mm	Under cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x8mm	4x8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes & Both Side]
10	Drilling Area Surface Smoothness		ok	
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

Ramanpreet 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

1	Counter Sinking Depth & Finish	ok						Counter - 30°
2	External Relief Dia	6.5mm, 7.0mm	6.5mm		7.0mm	ADD ROW		ROW - 19
3	External Relief Depth		2.6mm		6mm			
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		10	09	24			

Inspected By (Sign) & Date

Ramanpreet Singh 10/09/24

Reviewed by (Engineer-CNC)

Manager-QA