



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.		12959	33/70
2	Machined By		V.T.L M/c Shop	Dr. No - LSP 377
3	Pallet Die No.		12928 (8.0mm)	(REV03)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 mm / Step od - 697.8mm	Step Length - 38.5 mm
6	Inside Diameter	Drg. No.	548.1 mm	Tapped - 5°
7	Width of Pellet Die	Drg. No.	215 mm	Under Wt - 1.8mm
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8mm / 29.5 x 10 x 8mm	6 x 8mm
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		618 mm	
13	Tapping Hole Diameter		M16 check by M16 Bolt	Face Side Step 1mm
14	Tapping On Second Side	Half pitch of 1st side	ok	Deep Both Side
15	Tapping Hole Depth		Drill Depth - 32.4mm / Tapping Depth - 30.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 25/09/24

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	9.0mm	All Rows						
3	External Relief Depth		37mm						
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		25	09	24				

Inspected By (Sign) & Date

Ramanjeet Singh 25/09/24

25/9/24

Reviewed by (Engineer-CNC)

Manager-QA