



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.		12916	30/50
2	Machined By		V.T.L M/c Shop	Drig No - LSD 932
3	Pallet Die No.		13021 (2.8mm)	(REV00)
4	Die Category	Drig. No.	Jumbo	
5	Out Side Diameter	Drig. No.	760mm	Step length - 26mm
6	Inside Diameter	Drig. No.	660.12mm	Tapper - 9.5°
7	Width of Pellet Die	Drig. No.	316mm	Undercut - 20.5mm
8	Grooves as per Drawing	Drig. No.	18 X 9 X 6mm / 18 X 9 X 6mm	
9	Fitting Sizes on CNC Plate	Drig. No.	ok	[Tapping No. of] Holes 12 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M 20 check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 22.4mm Tapping Depth - 20.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet 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

1	Counter Sinking Depth & Finish	ok							Counter - 60° Row - 59
2	External Relief Dia	3.3mm	outside (3-3)	Inner					
3	External Relief Depth		23mm	20mm					
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		25	09	24				

Inspected By (Sign) & Date

Ramanpreet Singh 25/09/24

Reviewed by (Engineer-CNC)

Manager-QA