



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.		11887	45/60
2	Machined By		V.T.L M/C Shop	Drg No - LSD-584
3	Pallet Die No.		10379 (8.0mm)	(Rev 01)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	78mm	Taper - 4°
6	Inside Diameter	Drg. No.	Step od - 798mm	Step length - 255mm
7	Width of Pellet Die	Drg. No.	660.12mm	Under cut - 9.0mm
8	Grooves as per Drawing	Drg. No.	324mm	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 10mm / 21.5 x 8 x 10mm	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 12 Both Side
11	Tapping Operator		M/C Shop	
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M20 check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 31mm Tapping Depth - 28.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 27/5/24

1	As per programme no.		—	[e slot] 32.1 mm width 8mm Deep Both Side
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 60°

1	Counter Sinking Depth & Finish	ok								Row-27
2	External Relief Dia	8.5mm	Outside (3-3)	Innec						
3	External Relief Depth		23mm	15mm						
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		27	5	24					

Inspected By (Sign) & Date

Ramanpreet Singh 27/5/24

Signature 27/5/24

Reviewed by (Engineer-CNC)

Manager-QA