



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.		12067	33/50
2	Machined By		V.T.L Mic Shop	Dr No - LSP 450
3	Pallet Die No.		12130 (3.0mm)	CREVOO
4	Die Category	Drg. No.	Jumbo EW	
5	Out Side Diameter	Drg. No.	730mm Step OD 743.4	Step length - 33.7
6	Inside Diameter	Drg. No.	630.12mm	Tapper 10°
7	Width of Pellet Die	Drg. No.	290mm	Outer cut 6.7mm
8	Grooves as per Drawing	Drg. No.	15x8x5mm 15x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 16 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		Mic Shop	
12	Tapping PCD		685mm	
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 - 20.4 Tapping Depth -	18.7mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 29/5/24

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 60

1	Counter Sinking Depth & Finish	ok							Row - 52
2	External Relief Dia	3.5mm	outside (3-3)	Inner					
3	External Relief Depth		23mm	17mm					
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		29	5	24				

Inspected By (Sign) & Date

Ramanjeet Singh. 29/5/24

Reviewed by (Engineer-CNC)

Manager-QA