



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.		12055	42/66 & 45/66
2	Machined By		V.T.L M/C Shop	Drg No - LSD-370
3	Pallet Die No.		12485 (8.0mm)	(REV 05)
4	Die Category	Drg. No.	M. Jumbo	0.1200K-4X3
5	Out Side Diameter	Drg. No.	680-8mm	Step Length - 31mm
6	Inside Diameter	Drg. No.	548 mm	Taper - 8°
7	Width of Pellet Die	Drg. No.	195 mm	Undercut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32X7X8mm / 32X7X8mm	4X8
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 4 Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		619mm	Face Side Step
13	Tapping Hole Diameter		M16 Check by M16 Bolt	2mm Deep Both
14	Tapping On Second Side	Half pitch of 1st side	ok	Side
15	Tapping Hole Depth		Drill Depth - 34.8mm	Tapping Depth - 32mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 03/6/24

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	1 st Pad	2 nd Pad				Row - 10
2	External Relief Dia	9.0mm	24mm	21mm				
3	External Relief Depth							
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	03	6	24				

Inspected By (Sign) & Date

Ramanjeet Singh 03/6/24

Satya 3/6/24

Reviewed by (Engineer-CNC)

Manager-QA