



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7660

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.		12121	32/42/50
2	Machined By		V.T.L Mic Shop	Drg No - LSP-633
3	Pallet Die No.		11664 (40mm)	(Rev 01)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	619.8mm	Step length - 20mm
6	Inside Diameter	Drg. No.	520.12mm	Taper - 12°
7	Width of Pellet Die	Drg. No.	186mm	Under cut - 1.9mm
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 12 Both Side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		Mic Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M16 check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.5mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 13/06/24

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 - 25
2	External Relief Dia	4.5mm, 5.0mm	4.5mm	5.0mm				
3	External Relief Depth		18mm	8mm				
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		13	06	24			

Inspected By (Sign) & Date

Ramanpreet Singh 13/06/24

Reviewed by (Engineer-CNC)

Manager-QA