



Lark Engineering Company (India) Pvt. Ltd.

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

7628

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.		12099	40/50/60
2	Machined By		V.T.L M/C Shop	Drg No - LSD 586
3	Pallet Die No.		12307 (4.0mm)	(Rev 00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm	Step OD - 802mm
6	Inside Diameter	Drg. No.	660.12mm	Step Length - 30mm
7	Width of Pellet Die	Drg. No.	290mm	Taper - 10°
8	Grooves as per Drawing	Drg. No.	27 X 8 X 7.5mm / 27 X 8 X 7.5mm	Under Cut - 11mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 12 Both Side
11	Tapping Operator		M/C Shop	
12	Tapping PCD		724mm	
13	Tapping Hole Diameter		M 22 check by M 22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 29.4mm Tapping Depth - 27.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 06/6/24

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

1	Counter Sinking Depth & Finish	ok					Counter - 60°
2	External Relief Dia		4.5mm	5.0mm			Row - 39
3	External Relief Depth		20mm	10mm			
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		06	6	24		

Inspected By (Sign) & Date

Ramanjeet Singh 06/6/24

Sat 06/6/24

Reviewed by (Engineer-CNC)

Manager-QA