



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11898	28/77
2	Machined By		V.T.L M/C Shop	Drg No - LSD-1042
3	Pallet Die No.		12369 (6.0mm)	(Rev00)
4	Die Category	Drg. No.	S. Jumbo	3200Vc-414mm
5	Out Side Diameter	Drg. No.	1004mm	Step Length - 45mm
6	Inside Diameter	Drg. No.	850.5mm	Taper - 8°
7	Width of Pellet Die	Drg. No.	266mm	Under cut - 3.8mm
8	Grooves as per Drawing	Drg. No.	45 X 6 X 10mm / 45 X 6 X 10	12 X 10mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 2
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		929mm / 928.4mm	Face Side Step
13	Tapping Hole Diameter		M20 check by M20 Bolt	2mm Deep Both
14	Tapping On Second Side	Half pitch of 1st side	ok	Side
15	Tapping Hole Depth		Drill Depth - 39mm	Tapping Depth - 34mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 07/06/24

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 - 30°

1	Counter Sinking Depth & Finish	ok							row - 16
2	External Relief Dia	7.5mm	All	Rows					
3	External Relief Depth		49mm						
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		07	06	24				

Inspected By (Sign) & Date

Ramanpreet Singh 07/06/24

Reviewed by (Engineer-CNC)

Manager-QA