



Lark Engineering Company (India) Pvt. Ltd.

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

7870

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.			
2	Machined By		12048	40/55
3	Pallet Die No.		V.T.L M/C Shop	Drg No-LSD 1061
4	Die Category	Drg. No.	12635 (8.0mm)	(Rev00)
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	425mm	Step od-388mm
7	Width of Pellet Die	Drg. No.	315.12mm	Step length-9.5mm
8	Grooves as per Drawing	Drg. No.	145mm	
9	Fitting Sizes on CNC Plate	Drg. No.	8X8X3mm	18X8X3mm
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes & Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		360mm	355mm
14	Tapping On Second Side	Half pitch of 1st side	M/R Check by / 3/4 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth-20.4mm	Tapping Depth-18.5mm
17	Visual Inspection Before Gun Drilling		Yes	
	Inspected By (Sign) & Date		Ramanpreet Singh 14/06/24	

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

1	Counter Sinking Depth & Finish	ok						Counter-80°
2	External Relief Dia	8.5mm	outside (2-2)	Inner				Row-11
3	External Relief Depth		23mm	15mm				
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	14	06	24				

Inspected By (Sign) & Date: Ramanpreet Singh 14/06/24

Reviewed by (Engineer-CNC): Saty 14/06/24

Manager-QA