



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.			
2	Machined By		12091	40/50/70
3	Pallet Die No.		V.T.L M/C Shop	Dwg No - LSP 377
4	Die Category	Drg. No.	12295 (8.0mm)	(REV 03)
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	6.88mm, Step od - 6.97.8mm	Step Length - 33.5mm
7	Width of Pellet Die	Drg. No.	548.12mm	Taper - 5°
8	Grooves as per Drawing	Drg. No.	215mm	Under Cut - 1.75mm
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 10 x 8 / 29.5 x 10 x 8mm	6 x 8mm
10	Drilling Area Surface Smoothness		ok	[Tapping No. of]
11	Tapping Operator		ok	Holes 2
12	Tapping PCD		M/C Shop	Both Side
13	Tapping Hole Diameter		618mm	Face Side Step
14	Tapping On Second Side	Half pitch of 1st side	M 16 Check by M 16 Bolt	1mm Deep Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 32.5mm Tapping Depth - 30.5mm	
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

Inspected By (Sign) & Date

Ramanjeet Singh 15/06/24

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 - 30°	Row - 12
2	External Relief Dia	8.5mm, 9.0mm	8.5mm		9.0mm			
3	External Relief Depth		30mm		20mm		All Rows	
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		15	06	24			

Inspected By (Sign) & Date

Ramanjeet Singh 15/06/24

Reviewed by (Engineer-CNC)

Manager-QA