



Lark Engineering Company (India) Pvt. Ltd.

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

71-80

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		12177	35/40
3	Pallet Die No.		V.T.L Mic Shop	Dr. No - 1SD 1073
4	Die Category	Drg. No.	12728 (3.0mm)	(Rev00)
5	Out Side Diameter	Drg. No.	SEW	
6	Inside Diameter	Drg. No.	500mm, Step od - 491mm,	Step Length - 16.5mm
7	Width of Pellet Die	Drg. No.	490-12mm,	
8	Grooves as per Drawing	Drg. No.	173mm,	
9	Fitting Sizes on CNC Plate	Drg. No.	10x8.5x5mm / 10x8.5x5mm,	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8 Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		Mic Shop	
13	Tapping Hole Diameter		455mm,	
14	Tapping On Second Side	Half pitch of 1st side	3/4 check by 3/4 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.4mm Tapping Depth - 13.5mm	
17	Visual Inspection Before Gun Drilling		Yes	
Inspected By (Sign) & Date			ok	
Inspected By (Sign) & Date			Ramanpreet Singh 17/06/24	
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 - 60° Row - 28
2	External Relief Dia	3.5mm	outside Inner	
3	External Relief Depth		12mm 5mm	
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		17 06 24	
Inspected By (Sign) & Date			Ramanpreet Singh 17/06/24	

Reviewed by (Engineer-CNC)

Manager-QA