

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.		12247	
2	Machined By		V.T.L Mic Shop	23/38/66 ✓
3	Pallet Die No.		1247 (6.0mm)	038 No- 45D 609
4	Die Category	Drg. No.	M. Jumbo groove 4x3mm	(Revol)
5	Out Side Diameter	Drg. No.	680.7mm	Step length - 31mm
6	Inside Diameter	Drg. No.	548.12mm	Tapper - 8°
7	Width of Pellet Die	Drg. No.	195mm	Under cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x8mm	4x3mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of
10	Drilling Area Surface Smoothness		ok	Holes 4
11	Tapping Operator		Mic Shop	Both Side
12	Tapping PCD		619mm	Face Side
13	Tapping Hole Diameter		M16 check by M16 Bolt	Step 2mm Deep
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth - 35mm Tapping Depth - 32mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 08/07/24

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°
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm			Row - 19
3	External Relief Depth	✓ ✓	38mm	28mm			
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		08	07	24		

Inspected By (Sign) & Date

Ramanpreet Singh 08/07/24

Reviewed by (Engineer-CNC)

Manager-QA