



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.		12392	27/66 25/30/66
2	Machined By		V.T.L M/c Shop	Dr. No - LSP 390
3	Pallet Die No.		12775	(Rev 06)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1mm Step 002-693.1mm	Step Length - 31mm
6	Inside Diameter	Drg. No.	548.12mm	Undercut = 0.85
7	Width of Pellet Die	Drg. No.	195mm	Tapper = 8°
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x8mm	4x8
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 4 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	Face Side Back Side
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 34mm Tapping Depth - 31.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 22/07/24

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

Counter - 30

1	Counter Sinking Depth & Finish	OK					Row-12
2	External Relief Dia	6.5mm, 7.0mm	1st Pad 7.0mm	2nd Pad 6.5mm	3rd Pad 7.0mm		
3	External Relief Depth		39mm	41mm	36mm		
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		22	07	24		

Inspected By (Sign) & Date

Ramanpreet Singh 22/07/24

Reviewed by (Engineer-CNC)

Manager-QA