



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.		12470	28/38/66
2	Machined By		V.T.L M/c Shop	Drg No-LSD 609
3	Pallet Die No.		12891 (6.0mm)	(Rev01)
4	Die Category	Drg. No.	M. Jumbo groove-4x3mm	
5	Out Side Diameter	Drg. No.	680.7mm	Step Length-31mm
6	Inside Diameter	Drg. No.	Step OD- 693mm	
7	Width of Pellet Die	Drg. No.	548.12mm	Taper-8°
8	Grooves as per Drawing	Drg. No.	195mm	Under cut-2.5mm
9	Fitting Sizes on CNC Plate	Drg. No.	32x7x8 mm / 32x7x8mm	4x8mm
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 4 Both side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Face side Step 2mm Deep Both side
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

Ramanjeet Singh 12/08/24

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	6.5mm	7.0mm					
3	External Relief Depth		38mm	28mm					
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		12	08	24				

Inspected By (Sign) & Date

Ramanjeet Singh 12/08/24

[Signature]
12/08/24

Reviewed by (Engineer-CNC)

Manager-QA