



# 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.		12470	28/38/66
2	Machined By		V.T.C M/c Shop	Drg No - LSP 609
3	Pallet Die No.		12892 (6.0mm)	(Rev 01)
4	Die Category	Drg. No.	M-Jumbo 3200 Vc 4X3mm	
5	Out Side Diameter	Drg. No.	680.7mm	Step length - 3mm
6	Inside Diameter	Drg. No.	548.12mm	Taper - 8°
7	Width of Pellet Die	Drg. No.	195mm	Undercut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32X7X8mm / 32X7X8mm	4X8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[ Tapping No. of Holes 4 ]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Both Side
12	Tapping PCD		619mm	Face Side Step
13	Tapping Hole Diameter		M16 Check by M16 Bolt	2mm Deep Both
14	Tapping On Second Side	Half pitch of 1st side	ok	Side
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 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	ADD ROWS			
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		12	08	24			

### Inspected By (Sign) & Date

Ramanpreet Singh 12/08/24

Reviewed by (Engineer-CNC)

Manager-QA