



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.L M/c Shop	Drg No - LSD 609
3	Pallet Die No.		12890 (6.0mm)	CRV01
4	Die Category	Drg. No.	M. Jumbo groove 4x3mm	
5	Out Side Diameter	Drg. No.	680.7mm Step od - 693mm	Step length - 31mm
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	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	
13	Tapping Hole Diameter		M16 check by M16 Bolt	Face Side Step
14	Tapping On Second Side	Half pitch of 1st side	ok	2mm Deep Both
15	Tapping Hole Depth		Drill Depth - 34mm Tapping Depth - 31mm	Side ✓
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
Row - 12

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5mm 27.0mm	6.5mm	7.0mm	All 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

12/8/24

Reviewed by (Engineer-CNC)

Manager-QA