



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.		12485	66/66
2	Machined By		V.T.C M/c Shop	Prog No- LSD 3P0
3	Pallet Die No.		12937 (10.0mm)	(REV 01)
4	Die Category	Drg. No.	M. Jumbo groove-4x3mm	
5	Out Side Diameter	Drg. No.	680.1mm	Step length-3mm
6	Inside Diameter	Drg. No.	Step-693mm	Taper-8°
7	Width of Pellet Die	Drg. No.	548.12mm	
8	Grooves as per Drawing	Drg. No.	195mm	
9	Fitting Sizes on CNC Plate	Drg. No.	32 X 7 X 8mm / 32 X 7 X 8mm	4 X 8mm
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes ? Both side]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	
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 16/08/24

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-60° Row-8

1	Counter Sinking Depth & Finish	OK	No Reliefs				
2	External Relief Dia	0	0	0			
3	External Relief Depth		0	0			
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		16	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 16/08/24

Sats 16/8/24

Reviewed by (Engineer-CNC)

Manager-QA