



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.		12800	30/66
2	Machined By		V.T.L M/c Shop	Drg No - LSD 390
3	Pallet Die No.		12943 (6.0mm)	CREV 06
4	Die Category	Drg. No.	M. Jumbo groove - 413mm	
5	Out Side Diameter	Drg. No.	680.1mm, step od - 623.1mm	Step Length - 31mm
6	Inside Diameter	Drg. No.	548.12mm	Taper - 8°
7	Width of Pellet Die	Drg. No.	194.7mm	Under cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8mm / 32 X 7 X 8mm	4 X 8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 2 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 2mm
14	Tapping On Second Side	Half pitch of 1st side	ok	Deep Both Side
15	Tapping Hole Depth		Drill Depth - 34.4mm Tapping Depth - 31.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 28/08/24

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	7.0mm	All Rows					
3	External Relief Depth		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		28	08	24			

Inspected By (Sign) & Date

Ramanpreet Singh 28/08/24

[Signature]
28/8/24

Reviewed by (Engineer-CNC)

Manager-QA