



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.		12794	55/88 ✓
2	Machined By		V.T.L M/c Shop	Des No - LSD 609
3	Pallet Die No.		13275 (8.0mm)	(Rev01)
4	Die Category	Drg. No.	M. Jumbo	2200Vc 4X3mm ✓
5	Out Side Diameter	Drg. No.	68.0mm	Step od - 69.3mm
6	Inside Diameter	Drg. No.	54.8mm	Step length - 31mm ✓
7	Width of Pellet Die	Drg. No.	195mm	Tapper - 8° ✓
8	Grooves as per Drawing	Drg. No.	32X7X8mm / 32X7X8mm	Under wt - 2.5mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	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		M 16 check by M 16 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 13/09/24

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 - 10

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	9.0mm	All Rows				
3	External Relief Depth	✓	11mm ✓				
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		13	09	24		

Inspected By (Sign) & Date

Ramanpreet Singh 13/09/24

Reviewed by (Engineer-CNC)

Manager-QA