



# 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.		12955 -	35/40/66 -
2	Machined By		V.T.L M/c Shop	Drg No - LSD 609
3	Pallet Die No.		13340 (6.0mm)	(REV 02)
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	680.7mm	Step Length - 31mm
6	Inside Diameter	Drg. No.	547.8mm	Taper - 8°
7	Width of Pellet Die	Drg. No.	195mm	Under wt - 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
10	Drilling Area Surface Smoothness		OK	Holes ?
11	Tapping Operator		M/c Shop	Both Side
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M 16 Check by M 16 Bolt	Face Side Step
14	Tapping On Second Side	Half pitch of 1st side	OK	2mm Deep Both
15	Tapping Hole Depth		Drill Depth - 33.5mm Tapping Depth - 31mm Side	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanpreet Singh 18/11/24

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					
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm	All Rows		
3	External Relief Depth		31mm	26mm			
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	11	24		

### Inspected By (Sign) & Date

Ramanpreet Singh 18/11/24

Reviewed by (Engineer-CNC)

Manager-QA