



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.		12054	25/66
2	Machined By		V.T.L M/C Shop	Drg No- LSD 320
3	Pallet Die No.		12484 (6.0mm)	(Rev 05)
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.	548mm	Tapper - 8°
7	Width of Pellet Die	Drg. No.	195mm	Under cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x8mm	4x8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of]
10	Drilling Area Surface Smoothness		ok	Holes 4
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		619mm	Face side Step
13	Tapping Hole Diameter		M 16 Check by M 16 Bolt	2mm Deep
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth - 35.8mm Tapping Depth - 32mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramandeep Singh 06/6/24

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

1	Counter Sinking Depth & Finish	ok					Counter - 30°
2	External Relief Dia	7.0mm	All Rows				Row - 12
3	External Relief Depth		41mm Deep				
4	Inspection Done Before Hardening By (Name)		Ramandeep Singh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		06	6	24		

Inspected By (Sign) & Date

Ramandeep Singh 06/6/24

Reviewed by (Engineer-CNC)

Manager-QA