



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.		12180	30/40/66
2	Machined By		V.T.L Mic Shop	Drg No-LSD 609
3	Pallet Die No.		12491 (6.0mm)	(Rev 01)
4	Die Category	Drg. No.	M. Jumbo groove-4X3mm	
5	Out Side Diameter	Drg. No.	680.7mm, Step of-693mm	Step length-3mm
6	Inside Diameter	Drg. No.	548.14mm	Taper-8°
7	Width of Pellet Die	Drg. No.	195mm	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]
10	Drilling Area Surface Smoothness		OK	Holes 4
11	Tapping Operator		Mic Shop	Both side
12	Tapping PCD		619mm	Face Step
13	Tapping Hole Diameter		M 16 check by M16 Bolt	2mm Deep
14	Tapping On Second Side	Half pitch of 1st side	OK	Both side
15	Tapping Hole Depth		Drill Depth-35mm Tapping Depth-	32mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanjeet Singh 22/06/24

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	6.5mm, 7.0mm	6.5mm	7.0mm			
3	External Relief Depth		38mm	26mm			All Rows
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		22	06	24		

Inspected By (Sign) & Date Ramanjeet Singh 22/06/24

Satyam
22/6/24

Reviewed by (Engineer-CNC)

Manager-QA