



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.		12187	36/66
2	Machined By		V.T.L M/c Shop	Drg No - LSP 609
3	Pallet Die No.		12487 (10.0mm)	(Rev 01)
4	Die Category	Drg. No.	M. Jumbo 320vc-4x3mm	
5	Out Side Diameter	Drg. No.	680.7mm	Step length - 31mm
6	Inside Diameter	Drg. No.	548.14mm	Taper - 8°
7	Width of Pellet Die	Drg. No.	195mm	Undercut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8 mm / 32 X 7 X 8 mm	4 X 8 mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 4 Both side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	Face Step 2mm
13	Tapping Hole Diameter		M16 check by M16 Bolt	Deep Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
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

Ramanpreet Singh 24/06/24

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 - 60, Row - 8

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	11.0mm							
3	External Relief Depth	30mm	ADD ROWS						
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		24	06	24				

Inspected By (Sign) & Date

Ramanpreet Singh 24/06/24

Sat 24/6/24

Reviewed by (Engineer-CNC)

Manager-QA