



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.		12322	33/50
2	Machined By		V.T.L M/C Shop	Drg No - LSD 450
3	Pallet Die No.		11880 (3.0mm)	(REV 00)
4	Die Category	Drg. No.	Jumbo EW	
5	Out Side Diameter	Drg. No.	730mm Stepod-743.4mm	Step Length-23mm
6	Inside Diameter	Drg. No.	630.14mm	Under cut-6.75mm
7	Width of Pellet Die	Drg. No.	290mm	Tapper-10°
8	Grooves as per Drawing	Drg. No.	15X8X5mm / 15X8X5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 16
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		685mm	
13	Tapping Hole Diameter		M 20 Check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 11/07/24

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 - 52

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5mm	outside (3-3)	Inner			
3	External Relief Depth		23mm	17mm			
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		1	07	24		

Inspected By (Sign) & Date

Ramanpreet Singh 11/07/24

Setyoo 11/7/24

Manager-QA

Reviewed by (Engineer-CNC)