



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.		12156	35/45/80
2	Machined By		V.T.L M/C Shop	Part No - LSD 700
3	Pallet Die No.		11431 (8.0mm)	(REV 02)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	730mm Step of - 732mm / 632mm	Step length - 30mm
6	Inside Diameter	Drg. No.	✓ 572.12mm ✓	Under cut - 1mm
7	Width of Pellet Die	Drg. No.	219mm	
8	Grooves as per Drawing	Drg. No.	58x8x8mm / 75x8x8mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 6
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		650mm ✓	
13	Tapping Hole Diameter		M16 check by M16 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	1 Side Tapping & 2nd Side 1 Slot ✓	
15	Tapping Hole Depth		Drill Depth - 40.5mm Tapping Depth - 38.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ramanpreet Singh 27/06/24	1 Slot - 32mm
1	As per programme no.		—	Width 19mm Deep
2	Gun Drilling Work Completed On		—	maintain after Hardening.
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°
1	Counter Sinking Depth & Finish	ok		Row - 6
2	External Relief Dia	8.5mm, 9.0mm	8.5mm	9.0mm
3	External Relief Depth		45mm ✓	35mm ALL 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		27 06 24	
Inspected By (Sign) & Date			Ramanpreet Singh 27/06/24	

Reviewed by (Engineer-CNC)
 Satya 27/6/24

Manager-QA