



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.		12139	48/70
2	Machined By		V.T.L M/C Shop	Drg No - LEC 12008 B
3	Pallet Die No.		11202 (4.0mm)	(Rev 01)
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1287mm	Step length - 28mm
6	Inside Diameter	Drg. No.	1045.12mm	
7	Width of Pellet Die	Drg. No.	388.5mm	
8	Grooves as per Drawing	Drg. No.	26 X 6 X 13mm / 26 X 6 X 13mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 20 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		1210mm	
13	Tapping Hole Diameter		M 24 check by M 24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 33.5mm Tapping Depth - 31.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 02/07/24

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 1 Hole close (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 60° ✓

1	Counter Sinking Depth & Finish	OK							Row - 56
2	External Relief Dia	4.8mm	outside (4-4)	Inner					
3	External Relief Depth		30mm	22mm					
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		02	07	24				

Inspected By (Sign) & Date

Ramanjeet Singh 02/07/24

Reviewed by (Engineer-CNC)

Manager-QA