



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.		12436	53/58
2	Machined By		V.T.L M/C Shop	Drg No-LSF 950
3	Pallet Die No.		12859 (38mm)	Chervo
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	716 mm, Step OD - 693 mm	Step length - 20mm
6	Inside Diameter	Drg. No.	600.12 mm	Tapper - 12°
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 mm 12 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 12
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		640 mm	
13	Tapping Hole Diameter		M20 check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.3 mm, Tapping Depth - 18.5 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 22/07/24

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

1	Counter Sinking Depth & Finish	OK						Row - 33
2	External Relief Dia	4.3 mm	outside (3-3)	Inner				
3	External Relief Depth		12 mm	5 mm				
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		22	07	24			

Inspected By (Sign) & Date

Ramanpreet Singh 22/07/24

Sotaj
22/07/24

Reviewed by (Engineer-CNC)

Manager-QA