



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7890

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.		12216	34/45/55
2	Machined By		V.T.L M/C Shop	Drg No- LSD 585
3	Pallet Die No.		12779 (3.5mm)	(REV00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770mm Step od- 802mm	Step length-30mm
6	Inside Diameter	Drg. No.	660.12mm	Under cut-16mm
7	Width of Pellet Die	Drg. No.	290mm	Tapper-10°
8	Grooves as per Drawing	Drg. No.	27 X 8 X 7.5 mm / 27 X 8 X 7.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 12 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		724mm	
13	Tapping Hole Diameter		M 22 Check by M 22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth- 29mm Tapping Depth- 27.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 25/07/24

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 / Hole close (B)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter-6°

1	Counter Sinking Depth & Finish	OK						Row-43
2	External Relief Dia	4.0mm, 4.5mm	4.0mm	4.5mm	All Rows			
3	External Relief Depth		21mm	10mm				
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		25	07	24			

Inspected By (Sign) & Date Ramanpreet Singh 25/07/24

Satyam
25/7/24

Reviewed by (Engineer-CNC)

Manager-QA