



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.		12330	50/80
2	Machined By		V.T.L M/C Shop	Prj No - LSP 859
3	Pallet Die No.		12075 (10.0mm)	(CRV02)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	730mm, step of - 732mm	132mm
6	Inside Diameter	Drg. No.	572.12mm	step length - 18.5mm
7	Width of Pellet Die	Drg. No.	119mm	
8	Grooves as per Drawing	Drg. No.	67x8x8mm / 28x8x8mm	
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		65mm	
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 - 40.4mm Tapping Depth - 29.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 16/07/24 1 Slot **36mm**

1	As per programme no.		—	Width 19mm
2	Gun Drilling Work Completed On		—	Deep
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 - 7
2	External Relief Dia	11.0mm	All Rows					
3	External Relief Depth		30mm					
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		16	07	24			

Inspected By (Sign) & Date

Ramanjeet Singh 16/07/24

Satya 16/7/24.
Reviewed by (Engineer-CNC)

Manager-QA