



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		19607 ✓	28/50 ✓
2	Machined By		V.T.L M/c Shop	Drg No-LSD 419
3	Pallet Die No.		12544 (4.0mm) ✓	(REV 00) ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 mm ✓	Step length-19.5mm ✓
6	Inside Diameter	Drg. No.	600.12mm ✓	
7	Width of Pellet Die	Drg. No.	222mm ✓	
8	Grooves as per Drawing	Drg. No.	12.5 X 8 X 7mm / 12.5 X 8 X 7mm ✓	
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		645mm ✓	
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- 22.4mm Tapping Depth- 20.5mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 13/08/24

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-32
2	External Relief Dia	4.5mm	Outside (3-3)	Innet					
3	External Relief Depth		26mm	22mm					
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		13	08	24				

Inspected By (Sign) & Date Ramanpreet Singh 13/08/24

Reviewed by (Engineer-CNC) S. S. 13/8/24

Manager-QA