



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.		12609	39/50
2	Machined By		V.T.L M/c Shop	Drg No - LSD 87P
3	Pallet Die No.		12817 (3.5mm)	(Rev00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	12003mm ^(B) Step of 6PP.5mm ^(A)	Step Length - 15.53/14.77
6	Inside Diameter	Drg. No.	520.12mm	Under cut - 1.2mm
7	Width of Pellet Die	Drg. No.	222mm	Taper - 1°
8	Grooves as per Drawing	Drg. No.	11x10x5mm / 11x10x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 12 Both Side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm	
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 16/08/24

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								
2	External Relief Dia	4.0mm	outside (3-3)	Inner						
3	External Relief Depth		18mm	11mm						
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		16	08	24					

Inspected By (Sign) & Date Ramanpreet Singh 16/08/24

Reviewed by (Engineer-CNC) Satish 16/08/24

Manager-QA