



Lark Engineering Company (India) Pvt. Ltd.

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

8118

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.		12444	39/60
2	Machined By		V.T.L M/c Shop	Drg No - LEC 11292
3	Pallet Die No.		7627 (3.0mm)	(REV 04)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	922mm ✓ Step of - 963mm	Step length - 45mm / 45.1
6	Inside Diameter	Drg. No.	802.12mm / 802.14mm (⊕)	Tap hole = 10°
7	Width of Pellet Die	Drg. No.	320mm	Wales cut = 20.5mm
8	Grooves as per Drawing	Drg. No.	37 x 9.5 x 10mm / 37 x 9.5 x 10mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 16 Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		865mm ✓	
13	Tapping Hole Diameter		M 30 check by M 30 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 40.4mm Tapping Depth - 38.3mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 31/08/24

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°
Row - 49

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5mm	outside (3-3)	Inner			
3	External Relief Depth		27mm	21mm			
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		31	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 31/08/24

[Signature]
31/8/24

Reviewed by (Engineer-CNC)

Manager-QA