



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.		12635	33/70
2	Machined By		V.T.L M/C Shop	Drig No - LSD 377
3	Pallet Die No.		10745 (8.0mm)	(REV 03)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688.8mm Step 0mm 697.8mm	Step Length - 38.5mm
6	Inside Diameter	Drg. No.	548.12mm	Tapper - 5°
7	Width of Pellet Die	Drg. No.	215mm	Under cut - 1.8mm
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8mm 29.5 x 10 x 8mm (6x8)	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of
10	Drilling Area Surface Smoothness		OK	Holes 2
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		68mm	
13	Tapping Hole Diameter		M16 check by M16 Bolt	Face Side Step
14	Tapping On Second Side	Half pitch of 1st side	OK	1mm Deeb
15	Tapping Hole Depth		Drill Depth - 32.4mm Tapping Depth - 30.4mm	Both Side
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

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

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-30°

1	Counter Sinking Depth & Finish	OK						Row-1P
2	External Relief Dia	9.0mm	All Rows					
3	External Relief Depth		37mm					
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		24	08	24			

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

[Signature]
24/08/24

Reviewed by (Engineer-CNC)

Manager-QA