



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.		12896 ✓	19/66 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 609
3	Pallet Die No.		12940 (6.0mm)	(Revol)
4	Die Category	Drg. No.	M. Jumbo 2200K-4X3 ✓	✓
5	Out Side Diameter	Drg. No.	680.1 mm ✓	Step length - 31mm
6	Inside Diameter	Drg. No.	548.12 mm ✓	Tapper - 8° ✓
7	Width of Pellet Die	Drg. No.	195 mm ✓	Under Cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32X7X8 mm / 32X7X8 mm	4X8mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	[Tapping No. of Holes 4 Both Side]
10	Drilling Area Surface Smoothness		OK ✓	
11	Tapping Operator		M/c Shop ✓	
12	Tapping PCD		619 mm ✓	
13	Tapping Hole Diameter		M16 Check by M16 Bolt ✓	Face Side Step 2mm
14	Tapping On Second Side	Half pitch of 1st side	OK ✓	Deep Both Side
15	Tapping Hole Depth		Drill Depth - 34.4mm Tapping Depth - 31.8mm ✓	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK ✓	

Inspected By (Sign) & Date Ramanjeet Singh 28/08/24

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 - 12
2	External Relief Dia	7.5 mm	All Rows					
3	External Relief Depth		47 mm ✓					
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		28	08	24			

Inspected By (Sign) & Date Ramanjeet Singh 28/08/24

[Signature]
28/08/24

Reviewed by (Engineer-CNC)

Manager-QA