



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.		12739	32/40/55
2	Machined By		V.T.L M/c Shop	Drg No - LSD 407
3	Pallet Die No.		12206 (4.0mm)	(Rev 00)
4	Die Category	Drg. No.	M. Jumbo	✓
5	Out Side Diameter	Drg. No.	710mm Step 00. 693mm	Stel length - 20mm
6	Inside Diameter	Drg. No.	600.12mm	Tabber = 12
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	12x8x7mm / 12x8x7mm	
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		640mm	✓
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 - 20.4mm Tapping Depth - 18.5mm	
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 - 60

1	Counter Sinking Depth & Finish	ok					Row - 32
2	External Relief Dia	4.5, 5.0mm	4.5mm	5.0mm	All Poles		
3	External Relief Depth		23mm	15mm			
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]
28/8/24

Reviewed by (Engineer-CNC)

Manager-QA