



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		1277P ✓	40/48/55
2	Machined By		V.T.C M/c Shop	Drw No- LSD 666
3	Pallet Die No.		12212 (6.0mm)	(Revoo)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710mm ✓	Step od- 693mm
6	Inside Diameter	Drg. No.	600.12mm ✓	Step length- 70mm
7	Width of Pellet Die	Drg. No.	222mm ✓	Tapper- 12
8	Grooves as per Drawing	Drg. No.	12 X 10 X 7.5mm / 12 X 10 X 7.5mm	
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		M to check by M to 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

Ramanpreet Singh 09/09/24

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- 22

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm	All Row		
3	External Relief Depth	✓	15mm	7mm			
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		09	09	24		

Inspected By (Sign) & Date

Ramanpreet Singh 09/09/24

Signature
09/09/24

Reviewed by (Engineer-CNC)

Manager-QA