



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.		12873	42/50
2	Machined By		V.T.L M/c Shop	Dwg No - LSD 413
3	Pallet Die No.		12552 (32mm)	(Rev 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 mm	Step length - 20mm
6	Inside Diameter	Drg. No.	600.12 mm / 600.14 mm	Tapper - 12
7	Width of Pellet Die	Drg. No.	322mm	
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 20 check by M 20 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 16/09/24

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 3 Hole close

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 60°
Row - 36

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.8mm	outside (3-3)	Inner			
3	External Relief Depth		15mm	8mm			
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		16	09	24		

Inspected By (Sign) & Date Ramanpreet Singh 16/09/24

Reviewed by (Engineer-CNC) Sethi 16/09/24

Manager-QA