



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.		12905	45/65
2	Machined By		V.T.L M/c Shop	Drg No - LSD 1151
3	Pallet Die No.		12979 (8.0mm)	(Rev00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790mm	Step od - 798mm
6	Inside Diameter	Drg. No.	660.12mm	Step Length - 25.5mm
7	Width of Pellet Die	Drg. No.	324mm	Taper - 4°
8	Grooves as per Drawing	Drg. No.	21.5 X 8 X 10mm / 21.5 X 8 X 10mm	Under cut - 4mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 12 Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		725mm	
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 - 30.4mm	Tapping Depth - 28.5mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 25/09/24

1	As per programme no.			2 Slot 32mm
2	Gun Drilling Work Completed On			Width 8mm Deep
3	Hole Finish In Gun Drilling	Marked	ok	Both Side
4	Defective Holes (If Any)		No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter - 60°
2	External Relief Dia	8.5mm	outside (33)	Inner				Row - 27
3	External Relief Depth		28mm	20mm				
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		25	09	24			

Inspected By (Sign) & Date

Ramanpreet Singh 25/09/24

[Signature]
25/09/24

Reviewed by (Engineer-CNC)

Manager-QA