



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.		12680 ✓	40/45/79 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 717
3	Pallet Die No.		12965 (8.0mm) ✓	(Revol) ✓
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1008mm ✓	Step Length - 41mm ✓
6	Inside Diameter	Drg. No.	850.1mm / 850.4mm ✓	41.3mm ✓
7	Width of Pellet Die	Drg. No.	265.7mm	Under cut - 2.44mm
8	Grooves as per Drawing	Drg. No.	45 X 8 X 10mm / 45 X 8 X 10mm	✓
9	Fitting Sizes on CNC Plate	Drg. No.	Rad 76mm x 2 OK	Tapping No. of Holes 2 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		935mm ✓	✓
13	Tapping Hole Diameter		M 20 check by M 20 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 - 42.4mm Tapping Depth - 40.5mm	✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 25/09/24

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 - 30

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	8.5mm, 9.0mm	8.5mm		9.5mm					
3	External Relief Depth	✓	39mm		34mm					ADD Rows
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		25	09	24					

Inspected By (Sign) & Date

Ramanjeet Singh 25/09/24

8/25/24

Reviewed by (Engineer-CNC)

Manager-QA