



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.		12056	55/60 ✓
2	Machined By		V.T.L M/C Shop	Drg No - LSP-413
3	Pallet Die No.		12020 (5.0mm)	(REV 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	720mm	Step length - 20mm
6	Inside Diameter	Drg. No.	600.12mm	Taper - 12°
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	14 X 8 X 7mm / 14 X 8 X 7mm	
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 - 23mm Tapping Depth - 20.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 31/5/24

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

1	Counter Sinking Depth & Finish	ok					Counter - 60°
2	External Relief Dia	5.5mm	outside (3-3)	Inner			Row - 26
3	External Relief Depth		15mm	5mm			
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh 31/5/24				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		31	5	24		

Inspected By (Sign) & Date Ramanpreet Singh 31/5/24

Reviewed by (Engineer-CNC) Sats 31/5/24

Manager-QA