



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.		12006	36150
2	Machined By		V.T.L M/C Shop	Drg No - LEC-R501
3	Pallet Die No.		12411 (3.0mm)	(Rev 01)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 mm	Step od - 692.8mm Step Length - 20mm
6	Inside Diameter	Drg. No.	600.12 mm	Taper - 12°
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 7 mm / 12 X 8 X 7 mm	
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		640 mm	
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 - 20.8 mm Tapping Depth - 18.7 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 01/6/24

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 - 62

1	Counter Sinking Depth & Finish	OK								Row - 39
2	External Relief Dia	3.5 mm	outside (3-3)	Inner						
3	External Relief Depth		20 mm	14 mm						
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		01	6	24					

Inspected By (Sign) & Date

Ramanpreet Singh 01/6/24

Reviewed by (Engineer-CNC)

Manager-QA