



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.		19091	40/50/70
2	Machined By		V.T.L M/C Shop	Drg No-LSD 377
3	Pallet Die No.		12294 (8.0mm)	(Rev 03)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 mm, Step od- 697.8mm	Step Length-32.5mm
6	Inside Diameter	Drg. No.	548-12mm	Taper-5°
7	Width of Pellet Die	Drg. No.	215mm	Under cut-1.75mm
8	Grooves as per Drawing	Drg. No.	29.5 X 10 X 8mm / 29.5 X 10 X 8mm	6 X 8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 2 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		618mm	Face Side Step
13	Tapping Hole Diameter		M16 Check by M16 Bolt	1mm Deep Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 32.5mm Tapping Depth - 30.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanjeet Singh 14/06/24

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					Row-12
2	External Relief Dia	8.5mm, 9.0mm	8.5mm		9.0mm		
3	External Relief Depth		30mm		20mm		
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	14	06	24			

Inspected By (Sign) & Date Ramanjeet Singh 14/06/24

Satya
14/06/24

Reviewed by (Engineer-CNC)

Manager-QA