



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.		12205	24/45
2	Machined By		V.T.L M/C Shop	Part No- LSD 652
3	Pallet Die No.		12417 (3.0mm)	(REV 00)
4	Die Category	Dr. No.	M. Jumbo	
5	Out Side Diameter	Dr. No.	690mm	Step Length-20mm
6	Inside Diameter	Dr. No.	600-12mm	Taper-12°
7	Width of Pellet Die	Dr. No.	222mm	Under cut-1.5mm
8	Grooves as per Drawing	Dr. No.	12x10x7.5mm / 12x10x7.5mm	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	[Tapping No. of Holes 12 Both Side]
10	Drilling Area Surface Smoothness		OK	
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-20.4mm Tapping Depth-18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 15/06/24

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 6 Hole close (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter-60

1	Counter Sinking Depth & Finish	OK						Row-38
2	External Relief Dia	3.5mm	outside (3-3)	Inner				
3	External Relief Depth		24mm	21mm				
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		15	06	24			

Inspected By (Sign) & Date Ramanpreet Singh 15/06/24

Reviewed by (Engineer-CNC) [Signature] 15/06/24

Manager-QA