



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7709

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.		12104	53/58
2	Machined By		V.T.L M/C Shop	Drg No - LEC 6986
3	Pallet Die No.		12777 (3.8mm)	(Rev 00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	776 mm	Step Length - 26mm
6	Inside Diameter	Drg. No.	660.12mm	25.8mm
7	Width of Pellet Die	Drg. No.	316 mm	Undercut - 12mm
8	Grooves as per Drawing	Drg. No.	20 X 8 X 7.5mm / 20 X 8 X 7.5mm	
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		725 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 - 25.5mm Tapping Depth - 23.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanpreet Singh 21/06/24	
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				
1	Counter Sinking Depth & Finish	OK		Row - 47
2	External Relief Dia	4.3 mm	outside (3-3) Inner	
3	External Relief Depth		12 mm 5 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		21 06 24	
Inspected By (Sign) & Date			Ramanpreet Singh 21/06/24	

Satsy 21/6/24

Reviewed by (Engineer-CNC)

Manager-QA