



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.		12113	52/66, 55/66
2	Machined By		V.T.L M/C Shop	Drg No - LSP 609
3	Pallet Die No.		12474 (8.0mm)	(Rev 01)
4	Die Category	Drg. No.	M. Jumbo groove-4x3mm	
5	Out Side Diameter	Drg. No.	680.7mm	Step of- 693mm
6	Inside Diameter	Drg. No.	548.14mm	Step Length-31mm
7	Width of Pellet Die	Drg. No.	195mm	Taper-8°
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x8mm	Under cut-2.5mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	4x8mm
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 4
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		619mm	Face Step 2mm
13	Tapping Hole Diameter		M 16 Check by M16 Bolt	Deel Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth- 35mm	Tapping Depth- 32mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanjeet Singh 20/06/24

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-10
2	External Relief Dia	9.0mm	1st Pad		2nd Pad				
3	External Relief Depth		14mm		11mm			All Rows	
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		20	06	24				

Inspected By (Sign) & Date Ramanjeet Singh 20/06/24

Satish
20/06/24

Reviewed by (Engineer-CNC)

Manager-QA