



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.		12212	25/35/60
2	Machined By		V.T.L M/C Shop	Drg No - LSD III
3	Pallet Die No.		12435 (6.0mm)	(REV 00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm / Step od - 792mm	Step length - 26.5mm
6	Inside Diameter	Drg. No.	660.12mm	Under cut - 6mm
7	Width of Pellet Die	Drg. No.	324mm	
8	Grooves as per Drawing	Drg. No.	21.5 X 8 X 8mm / 21.5 X 8 X 8mm	
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		725mm	
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 - 31.5mm Tapping Depth - 29.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanpreet Singh 11/07/24	
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 3 Hole close	
Note : Mark the defective holes/missed holes with the help of Permanent Marker Counter - 60° Row - 34				
1	Counter Sinking Depth & Finish	OK		
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm
3	External Relief Depth		35mm	25mm All Rows
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		1	07 24
Inspected By (Sign) & Date			Ramanpreet Singh 11/07/24	

Reviewed by (Engineer-CNC)

Manager-QA