



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.		12161	30/45
2	Machined By		V.T.L M/C Shop	Drg No- LSD 483
3	Pallet Die No.		12769 (50mm)	(REV 03)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400mm / Step OD-387mm	Step Length-10.5mm
6	Inside Diameter	Drg. No.	310.12mm	
7	Width of Pellet Die	Drg. No.	134mm	
8	Grooves as per Drawing	Drg. No.	8X7X3mm / 8X7X3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 8 Both Side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		350mm	
13	Tapping Hole Diameter		1/2" check by 1/2" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth-16.5mm Tapping Depth-14.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 27/06/24

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-60°

1	Counter Sinking Depth & Finish	OK						Row-15
2	External Relief Dia	5.5mm	outside (2-3)	Inner				
3	External Relief Depth		20mm	15mm				
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		27	06	24			

Inspected By (Sign) & Date

Ramanpreet Singh 27/06/24

Signature
27/6/24

Reviewed by (Engineer-CNC)

Manager-QA