



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.		12244 ✓	30/55/75 ✓
2	Machined By		V.T.L M/C Shop	Drg No - LSP 824
3	Pallet Die No.		10439 (6.0mm)	(REV00) ✓
4	Die Category	Drg. No.	MJEW	
5	Out Side Diameter	Drg. No.	722 mm ✓	Step on. 777 mm ✓
6	Inside Diameter	Drg. No.	572.12 mm ✓	Step depth - 42 mm ✓
7	Width of Pellet Die	Drg. No.	270 mm ✓	24.5 mm ✓
8	Grooves as per Drawing	Drg. No.	106 x 8 x 12 mm ✓	88 x 8 x 12 mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	Tapping No. of Holes 6
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		660 mm ✓	
13	Tapping Hole Diameter		3/4 check by 3/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and 1st side One Sl.	
15	Tapping Hole Depth		Drill Depth - 26.4 Tapping Depth - 33.5 mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 03/07/24

1	As per programme no.		—	1 SLOT 39 mm width 26 mm Depth
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 - 7
2	External Relief Dia	6.5mm, 7.0mm	6.5mm		7.0mm			
3	External Relief Depth		45mm		20mm			
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		03	07	24			

Inspected By (Sign) & Date

Ramanjeet Singh 03/07/24

Saty 3/7/24

Reviewed by (Engineer-CNC)

Manager-QA