



Lark Engineering Company (India) Pvt. Ltd.

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

7750

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.			
2	Machined By		12P49	29/40
3	Pallet Die No.		Y.T.L Mic Shop	Drg No - LEC 7592
4	Die Category	Drg. No.	11842 (3.0mm)	(REV00)
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500mm	Step length - 17.5mm
7	Width of Pellet Die	Drg. No.	420.12mm	
8	Grooves as per Drawing	Drg. No.	158mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x5mm / 12x8x5mm	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8 Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		Mic Shop	
13	Tapping Hole Diameter		455mm	
14	Tapping On Second Side	Half pitch of 1st side	3/4" check by 3/4 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 22.3mm Tapping Depth - 20.5mm	
17	Visual Inspection Before Gun Drilling		Yes	

Inspected By (Sign) & Date

Ramanpreet Singh 29/06/24

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					Counter - 60°
2	External Relief Dia	3.5mm	outside (7-2)	Inner			Row - 24
3	External Relief Depth		14mm	11mm			
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		29	06	24		

Inspected By (Sign) & Date

Ramanpreet Singh 29/06/24

Signature
29/06/24

Reviewed by (Engineer-CNC)

Manager-QA