



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12171	36/45
2	Machined By		V.T.L M/C SHOP	Drg No- LSP 958
3	Pallet Die No.		1266 (3.0mm)	(Key 00)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395mm	Step OD - 383mm
6	Inside Diameter	Drg. No.	304.12 / 305.12mm	Step Length - 12mm
7	Width of Pellet Die	Drg. No.	100mm	
8	Grooves as per Drawing	Drg. No.	10x7x4mm / 10x7x4mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes & Both Side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C SHOP	
12	Tapping PCD		349mm	
13	Tapping Hole Diameter		M/R Check by M/R Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 18.3mm	Tapping Depth - 16.4mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 10/07/24

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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 60°
Row - 14

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5mm	outside (P-2)	Inner			
3	External Relief Depth		15mm	9mm			
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		10	07	24		

Inspected By (Sign) & Date

Ramanjeet Singh 10/07/24

Reviewed by (Engineer-CNC)

Manager-QA