



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.		1234	40/40
2	Machined By		V.T.L M/C Shop	Drg No - LSD 881
3	Pallet Die No.		12730 (4.0mm)	(REV00)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500mm, Step OD - 490.7mm	Step Length - 16.5mm
6	Inside Diameter	Drg. No.	490.12mm	
7	Width of Pellet Die	Drg. No.	173mm	
8	Grooves as per Drawing	Drg. No.	12 X 10 X 5mm / 12 X 10 X 5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 8]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		455mm	
13	Tapping Hole Diameter		3/4 check by 3/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet 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°

1	Counter Sinking Depth & Finish	OK							Row - 22
2	External Relief Dia	4.3mm	outside (2-2)	Inner					
3	External Relief Depth		4mm	0					
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		10	07	24				

Inspected By (Sign) & Date

Ramanpreet Singh 10/07/24

Sasouli 10/7/24

Reviewed by (Engineer-CNC)

Manager-QA