



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.		12298	45/50
2	Machined By		V.T.L M/c Shop	Prj No - LSD 695
3	Pallet Die No.		12902 (8.0mm)	(REV 00)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	415 mm, Step od - 389 mm	Step length - 9.5mm
6	Inside Diameter	Drg. No.	315.12 mm	
7	Width of Pellet Die	Drg. No.	145 mm	
8	Grooves as per Drawing	Drg. No.	15 X 8 X 3 mm / 15 X 8 X 3 mm	
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		355 mm / 362 mm	
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 - 20 mm / 15 mm, Tapping Depth - 18.5 mm / 13.5 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanpreet Singh 24/07/24	
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 - 80° Row - 10				
1	Counter Sinking Depth & Finish	OK		
2	External Relief Dia	8.5 mm	outside 12.7, Inner 5 mm	
3	External Relief Depth		13 mm	
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		24 07 24	
Inspected By (Sign) & Date			Ramanpreet Singh 24/07/24	

Reviewed by (Engineer-CNC)
Santosh 24/7/24

Manager-QA