



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.		12341	45/50	
2	Machined By		V.T.L Mic Shop	Drg No-LSP 1084	
3	Pallet Die No.		12286 (6.0mm)	(Rev00)	
4	Die Category	Drg. No.	SEW		
5	Out Side Diameter	Drg. No.	520mm 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.	12x10x5mm / 12x10x5mm		
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes & Both Side	
10	Drilling Area Surface Smoothness		OK		
11	Tapping Operator		Mic Shop		
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-20.3mm Tapping Depth-18.5mm		
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ramanjeet Singh 12/07/24		
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					
1	Counter Sinking Depth & Finish	OK	Counter-60° Rdw-18		
2	External Relief Dia	6.5mm	outside (2-2)	Inner	
3	External Relief Depth		11mm	5mm	
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		12	07	24
Inspected By (Sign) & Date			Ramanjeet Singh 12/07/24		

Reviewed by (Engineer-CNC)

Manager-QA