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.		12532	30/40
2	Machined By		V.T.L M/c Shop	Drg No-LEC 15068
3	Pallet Die No.		11290 (3.0mm)	CRV00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm Step of 498.8mm	Step Length - 13mm
6	Inside Diameter	Drg. No.	420.12mm	Taper - 12°
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12X8X3mm / 12X8X3mm	
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		454mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ramanpreet Singh 31/07/24	
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 - 1 Hole Closed (A)	

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

								Counter - 60°
1	Counter Sinking Depth & Finish	OK						Row - 24
2	External Relief Dia	3.5mm	Outside (Q-2)	Inner				
3	External Relief Depth		13mm	6mm				
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		31	07	24			
	Inspected By (Sign) & Date		Ramanpreet Singh 31/07/24					

Satya 31/7/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner