



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.		12480	42/50
2	Machined By		V.T.L M/c Shop	Drg No-LSP 777
3	Pallet Die No.		12901 (5.0mm)	(Rev 00)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410 mm	Step od-388mm
6	Inside Diameter	Drg. No.	310.12mm	Step length-95mm
7	Width of Pellet Die	Drg. No.	146mm	
8	Grooves as per Drawing	Drg. No.	15 X 8 X 3mm / 15 X 8 X 3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 4 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		352mm	
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-25.3mm Tapping Depth-23.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 06/08/24

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-14
2	External Relief Dia	5.5mm	Outside (2-2)	Inner					
3	External Relief Depth		13mm	8mm					
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		06	08	24				

Inspected By (Sign) & Date

Ramanjeet Singh 06/08/24

Satya 6/8/24

Reviewed by (Engineer-CNC)

Manager-QA