



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.		1P44P	4P/55
2	Machined By		VTL M/C SHOP	Part No. LSP 490
3	Pallet Die No.		19901 (60mm)	CREV001
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	710mm	step length - 19.5mm
6	Inside Diameter	Drg. No.	600.19mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	19.5 X 8 X 7mm / 19.5 X 8 X 7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 19 Both side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C SHOP	
12	Tapping PCD		645mm	
13	Tapping Hole Diameter		M 20 check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 22.3mm Tapping Depth - 20.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 07/08/24

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-23
2	External Relief Dia	6.5mm	outside (3-3)	Inner					
3	External Relief Depth		19mm	13mm					
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		07	08	24				

Inspected By (Sign) & Date

Ramanpreet Singh 07/08/24

Satyam 7/8/24

Reviewed by (Engineer-CNC)

Manager-QA