



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

8014

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12717 ✓	30/47 ✓
2	Machined By		V.T.L Mic Shop	Dr. No - LEC 1543
3	Pallet Die No.		11629 (3.0mm) ✓	CRK00 ✓
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	61444 ✓	Step length 19.5mm ✓
6	Inside Diameter	Drg. No.	520.12 mm ✓	
7	Width of Pellet Die	Drg. No.	2223mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 12 Both Side ✓
11	Tapping Operator		Mic Shop	
12	Tapping PCD		565mm ✓	
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 - 20.8 mm Tapping Depth - 18.7 mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 21/08/24

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, Row-38

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5mm	outside (3-3)	Inner			
3	External Relief Depth		20mm	17mm			
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		21	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 21/08/24

Signature
21/8/24

Reviewed by (Engineer-CNC)

Manager-QA