



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.		12639 ✓	70/70 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 1051
3	Pallet Die No.		13028 (3.0mm)	(REV00) ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770 H/H, Step OD, 743.5	Step length - 23mm
6	Inside Diameter	Drg. No.	630.12 H/H	Tapper = 10°
7	Width of Pellet Die	Drg. No.	265mm ✓	
8	Grooves as per Drawing	Drg. No.	15 x 8 x 5mm / 15 x 8 x 5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 16 Both side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		685mm ✓	
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 - 20.4 H/H, Tapping Depth - 18.5 H/H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 28/08/24

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 1 Hole close (A)

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

Counter - 60

1	Counter Sinking Depth & Finish	OK							Row - 48
2	External Relief Dia	No Relief							
3	External Relief Depth								
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		28	08	24				

Inspected By (Sign) & Date

Ramanjeet Singh 28/08/24

Reviewed by (Engineer-CNC)

Manager-QA