



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.		12678 ✓	40/55 ✓
2	Machined By		V.T.L M/c Shop	Dwg No. - LSD 355
3	Pallet Die No.		12673 (3.8mm)	(REV00)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	629.9mm Step OD - 612mm	Step length - 20mm
6	Inside Diameter	Drg. No.	570.12mm	
7	Width of Pellet Die	Drg. No.	186mm ✓	
8	Grooves as per Drawing	Drg. No.	13 X 8 X 3mm / 13 X 8 X 3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	[Tapping No. of Holes 12 Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm ✓	
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 - 20.5mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 25/08/24

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								
2	External Relief Dia	4.3mm	outside (3-3)	Inner						
3	External Relief Depth		19mm	15mm						
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		25	08	24					

Inspected By (Sign) & Date

Ramanjeet Singh 25/08/24

Reviewed by (Engineer-CNC)

Manager-QA