



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		1P6P2	36/50
2	Machined By		V.T.L	Drg No - LEC 9980
3	Pallet Die No.		M/c Shop	(REV00) /
4	Die Category	Drg. No.	1P836 (3.0mm)	
5	Out Side Diameter	Drg. No.	SSEW	
6	Inside Diameter	Drg. No.	620mm ✓	Step length - 18.5mm
7	Width of Pellet Die	Drg. No.	520.19mm / 520.14	
8	Grooves as per Drawing	Drg. No.	PP2mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm / 13x8x5mm	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 12 Both Side
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 - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 27/08/24

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		9mm	14mm			
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		27	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 27/08/24

Reviewed by (Engineer-CNC)

Manager-QA