



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.		12727 ✓	40/50 ✓
2	Machined By		V.T.L Mic Shop	Dwg No- LSD 493
3	Pallet Die No.		12547 (4.0mm)	(Rev00) ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700mm ✓	Step OD - 693mm
6	Inside Diameter	Drg. No.	600.12mm ✓	Step length - 20mm
7	Width of Pellet Die	Drg. No.	222mm ✓	Top - 12 ✓
8	Grooves as per Drawing	Drg. No.	12x10x7.5mm / 12x10x7.5mm ✓	
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		640mm ✓	
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

Ramanjeet Singh 29/08/24

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

1	Counter Sinking Depth & Finish	ok							Counter - 60°
2	External Relief Dia	4.5mm	outside (33)	Inner					Row - 31
3	External Relief Depth		14mm	10mm					
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		29	08	24				

Inspected By (Sign) & Date

Ramanjeet Singh 29/08/24

Reviewed by (Engineer-CNC)

Manager-QA