



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.		12709 ✓	35/55/70
2	Machined By		V.T.L M/c Shop	Drg No - LSD 648
3	Pallet Die No.		12961 (6.0mm)	C Rev 04
4	Die Category	Drg. No.	MJEW ✓	
5	Out Side Diameter	Drg. No.	712mm ✓	Step od - 777/776mm
6	Inside Diameter	Drg. No.	572.12mm ✓	Step Length - 24.5mm ✓
7	Width of Pellet Die	Drg. No.	270mm ✓	Under Cut - 32.5mm ✓
8	Grooves as per Drawing	Drg. No.	106 X 8 X 12mm / 88 X 8 X 12mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 6
11	Tapping Operator		M/c Shop	
12	Tapping PCD		660mm ✓	
13	Tapping Hole Diameter		3/4 Check by 3/4 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	1 Side Tapping 2nd Side 1 Slot ✓	
15	Tapping Hole Depth		Drill Depth - 35.4mm Tapping Depth - 33.5mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ramanpreet Singh 30/08/24	1 Slot 39mm
1	As per programme no.		—	Width 26mm
2	Gun Drilling Work Completed On		—	Deep ✓
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° Row - 7
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm All Rows
3	External Relief Depth	✓	35mm	15mm ✓
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		30 08 24	
Inspected By (Sign) & Date			Ramanpreet Singh 30/08/24	

Signature
30/8/24

Reviewed by (Engineer-CNC)

Manager-QA