



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.		12794	66/66
2	Machined By		V.T.L M/c Shop	Drg No- LSP 609
3	Pallet Die No.		13181 (10.0mm)	Revol
4	Die Category	Drg. No.	M. Jumbo groove-4X3mm	
5	Out Side Diameter	Drg. No.	680.1mm Step od- 693mm	Step Length- 31mm
6	Inside Diameter	Drg. No.	548.12mm	
7	Width of Pellet Die	Drg. No.	195mm	
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8mm / 32 X 7 X 8mm	4 X 8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 4 Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M 16 check by M 16 Bolt	Face Side Step 2mm
14	Tapping On Second Side	Half pitch of 1st side	ok	Deep Both Side
15	Tapping Hole Depth		Drill Depth- 34mm Tapping Depth- 31.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 02/09/24

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								Row-8
2	External Relief Dia	No Relief	—							
3	External Relief Depth		—							
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		09	09	24					

Inspected By (Sign) & Date

Ramanpreet Singh 02/09/24

Saty 21/9/24

Reviewed by (Engineer-CNC)

Manager-QA