



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.		12657 ✓	32/40 (b)
2	Machined By		V.T.L M/c Shop	Drg No - LSD 777
3	Pallet Die No.		12352 (3.0mm) ✓	CREVO ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm ✓	Step Length - 13.5mm ✓
6	Inside Diameter	Drg. No.	420.12mm (A) ✓	
7	Width of Pellet Die	Drg. No.	152mm ✓	
8	Grooves as per Drawing	Drg. No.	11x5x3mm / 11x5x3mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8 Both Side]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		456mm ✓	
13	Tapping Hole Diameter		3/4" check by 3/4" Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	
15	Tapping Hole Depth		Drill Depth - 16.4mm Tapping Depth - 14.5mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ramanpreet Singh 06/09/24	Approval By Sales
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 / Hole close (A)	
Note : Mark the defective holes/missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter-60° Row - 24
2	External Relief Dia	3.5mm	Outside (CP-2) Inner	
3	External Relief Depth		14mm 8mm	
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		06 09 24	
Inspected By (Sign) & Date			Ramanpreet Singh 06/09/24	

Satyam 06/09/24

Reviewed by (Engineer-CNC)

Manager-QA