



Lark Engineering Company (India) Pvt. Ltd.

ITI 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		19713	65/65
2	Machined By		VTL M/c Shop	Des No - 15D 1170
3	Pallet Die No.		7997 (7.5mm)	(Rev 00)
4	Die Category	Drg. No.	SLW	
5	Out Side Diameter	Drg. No.	550mm	Step length - 18mm
6	Inside Diameter	Drg. No.	470.12mm	Tolerance - 12
7	Width of Pellet Die	Drg. No.	182mm	
8	Grooves as per Drawing	Drg. No.	12x 8x 3mm / 12x 8x 3mm	
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		454mm	
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 - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 06/09/24

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 - 22
2	External Relief Dia	5.0mm	outside (3-3)	Inner					
3	External Relief Depth		9mm	0					
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

Signature
6/9/24

Reviewed by (Engineer-CNC)

Manager-QA