



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.		12757 ✓	35/43 ✓
2	Machined By		V.T.C M/c Shop	Drg No-LSD/1009
3	Pallet Die No.		12761 (4.5mm)	(Rev00)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	399 mm	Step OD-383 mm
6	Inside Diameter	Drg. No.	313.12 mm ✓	Step length-10 mm ✓
7	Width of Pellet Die	Drg. No.	146 mm ✓	
8	Grooves as per Drawing	Drg. No.	14x6x3mm / 14x6x3mm	
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		352 mm ✓	
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-20.4 mm Tapping Depth-18.5 mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 09/09/24

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°
Row-17 ✓

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.0 mm	outside (P-P)	Inner			
3	External Relief Depth		13 mm	8 mm			
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 09/09/24

Signature
09/09/24

Reviewed by (Engineer-CNC)

Manager-QA