



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8185

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.		12769 ✓	35/55 ✓
2	Machined By		V-T L Mic Shop	Dwg No - LSD 755
3	Pallet Die No.		11541 (4.5mm)	(REV 00) ✓
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	73744 ✓ Step 00, 7543	Step Length - 29mm
6	Inside Diameter	Drg. No.	6301244 (Bar - 62744)	Tapping ✓
7	Width of Pellet Die	Drg. No.	256mm ✓	Under note - 865 ✓
8	Grooves as per Drawing	Drg. No.	19.5 X 10 X 8mm / 19.5 X 10 X 8mm	⊙
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 12]
11	Tapping Operator		Mic Shop	[Both Side] ✓
12	Tapping PCD		689mm ✓	
13	Tapping Hole Diameter		M24 check by M24 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	
15	Tapping Hole Depth		Drill Depth - 28.4mm Tapping Depth - 26.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 11/09/24

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 / Hole close ⊙	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 60
ROW - 31 ✓

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.0mm	outside (3-3)	Inner			
3	External Relief Depth	✓	25mm	20mm			
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		11	09	24		

Inspected By (Sign) & Date

Ramanpreet Singh 11/09/24

Signature

Reviewed by (Engineer-CNC)

Manager-QA