



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.		12747	28/50
2	Machined By		V.T.C M/c Shop	Drg No - LSD 344
3	Pallet Die No.		11999 (P.8mm)	CREV00
4	Die Category	Drg. No.	MJEW	
5	Out Side Diameter	Drg. No.	700mm	Step length - 19.5mm
6	Inside Diameter	Drg. No.	Step OD - 692mm	
7	Width of Pellet Die	Drg. No.	600.12mm	
8	Grooves as per Drawing	Drg. No.	265mm	
9	Fitting Sizes on CNC Plate	Drg. No.	15 X 8 X 7mm / 15 X 8 X 7mm	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 16 Both Side]
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	
13	Tapping Hole Diameter		640mm	
14	Tapping On Second Side	Half pitch of 1st side	M to check by M to Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Ramanpreet Singh 12/09/24

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 3 Hole close	

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

Counter - 60°
Row - 49

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.3mm	outside (3-3)	Innre			
3	External Relief Depth		25mm	22mm			
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		12	09	24		

Inspected By (Sign) & Date

Ramanpreet Singh 12/09/24

Sotav
12/09/24

Reviewed by (Engineer-CNC)

Manager-QA