



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		1P770	35/40
2	Machined By		V.T.L M/c Shop	Drg No - LEC 9567
3	Pallet Die No.		1P735 (3.0mm)	(REV 01)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500 mm Step 00.492.8	Step length - 17.5mm
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	182mm	
8	Grooves as per Drawing	Drg. No.	10x10x4mm / 10x10x4mm	
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		455mm	
13	Tapping Hole Diameter		M20 check by M20 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 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	

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

Counter - 60°
Row - 30

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5mm	OUTSIDE CP-P	2mm			
3	External Relief Depth		11mm	5mm			
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

Signature
12/09/24

Reviewed by (Engineer-CNC)

Manager-QA