



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.		19826	32/42/50
2	Machined By		V.T.L Mic Shop	Drg No-LSD 633
3	Pallet Die No.		11862 (40mm)	(Rev01)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620mm	Step on 623.5
6	Inside Diameter	Drg. No.	520.12mm	Step length-90mm
7	Width of Pellet Die	Drg. No.	186mm	Tapper 12"
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	Under cut 1.8mm
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	
12	Tapping PCD		565mm	Both Side
13	Tapping Hole Diameter		M16 check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth-20.4mm Tapping Depth-18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 13/09/24

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								
2	External Relief Dia	4.5mm, 5.0mm	4.5mm		5.0mm					
3	External Relief Depth		18mm		8mm					
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		13	09	24					

Inspected By (Sign) & Date

Ramanjeet Singh 13/09/24

Sats 14/9/24

Reviewed by (Engineer-CNC)

Manager-QA