



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.		12889	34/40
2	Machined By		VTL M/c Shop	Drg No - LSP 04
3	Pallet Die No.		19737 (4.0mm)	(REV 01)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500mm	Step length - 17mm
6	Inside Diameter	Drg. No.	Step of - 471mm 420.12mm ✓	
7	Width of Pellet Die	Drg. No.	182mm ✓	
8	Grooves as per Drawing	Drg. No.	10x10x5mm / 10x10x5mm ✓	
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		3/4" check by 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 19.4mm Tapping Depth - 17.5mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 17/09/24

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-25

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5mm	outside (2-2)	Inner			
3	External Relief Depth		10mm	6mm			
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		17	09	24		

Inspected By (Sign) & Date Ramanpreet Singh 17/09/24

Sats
17/9/24

Reviewed by (Engineer-CNC)

Manager-QA