



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.		12897 ✓	35/40 ✓
2	Machined By		V.T.C M/c Shop	Drg No - LSD 33
3	Pallet Die No.		12736 (3.5mm) ✓	(REV 01)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500 mm ✓	Step od - 491 mm ✓
6	Inside Diameter	Drg. No.	420.12 mm ✓	Step length - 17.5 mm ✓
7	Width of Pellet Die	Drg. No.	182 mm ✓	
8	Grooves as per Drawing	Drg. No.	10 X 8 X 3 mm / 10 X 8 X 3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 8 Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454 mm ✓	
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 - 18.4 mm Tapping Depth - 16.5 mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 25/09/24

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

1	Counter Sinking Depth & Finish	ok							Counter - 60° Row - 28
2	External Relief Dia	4.0 mm	out side (P-P)	Inner					
3	External Relief Depth		8 mm	5 mm					
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		25	09	24				

Inspected By (Sign) & Date

Ramanjeet Singh 25/09/24

Satish 25/9/24

Reviewed by (Engineer-CNC)

Manager-QA