



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.		12854 ✓	45/50 ✓
2	Machined By		V.T.L Mic Shop	Drg No - LSD 370
3	Pallet Die No.		11871 (6.0mm)	(Rev 00) ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5.19 mm (5) Step of - 491mm / 490.4mm	Step length - 19mm / 17.5mm
6	Inside Diameter	Drg. No.	420.12 mm ✓	
7	Width of Pellet Die	Drg. No.	159.5mm ✓	
8	Grooves as per Drawing	Drg. No.	13.5 X 8 X 3mm / 12 X 8 X 3mm	
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		Mic Shop	
12	Tapping PCD		454mm ✓	
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 - 18.4mm Tapping Depth - 16.5mm ✓	
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

Counter-60°

1	Counter Sinking Depth & Finish	OK								Row - 15
2	External Relief Dia	6.5mm	outside (2-2)	Inner						
3	External Relief Depth		11mm	5mm ✓						
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

Reviewed by (Engineer-CNC)

Manager-QA