



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.		12661 ✓	40/50
2	Machined By		V.T.C M/c Shop	Drg No - LSD 405
3	Pallet Die No.		13430 (3.5mm) ✓	(REV 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520mm Step OD - 499mm	Step length - 17mm
6	Inside Diameter	Drg. No.	420.12mm ✓	Taper - 12° ✓
7	Width of Pellet Die	Drg. No.	158mm ✓	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 3mm / 12 X 8 X 3mm ✓	
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		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

Ramanpreet Singh 26/09/24

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 - 800 ✓

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.0mm	outside CR-P	Inner					
3	External Relief Depth		17mm	10mm					
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		26	09	24				

Inspected By (Sign) & Date

Ramanpreet Singh 26/09/24

Reviewed by (Engineer-CNC)

Manager-QA