



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)

8278

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12946 ✓	36/40
2	Machined By		V.T.L M/c Shop	Drg No- LSD 905
3	Pallet Die No.		12462 (3.0mm)	(REV 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm Stel od- 491mm	Stel length- 17.5mm
6	Inside Diameter	Drg. No.	420.12mm ✓	
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	[Tapping No. of] Holes 8 Both Side
10	Drilling Area Surface Smoothness		ok	
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 60

1	Counter Sinking Depth & Finish	ok							Row- 24
2	External Relief Dia	3.5mm	outside CP-D	Inner					
3	External Relief Depth	✓	10mm	4mm ✓					
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

Saty 26/9/24

Reviewed by (Engineer-CNC)

Manager-QA