



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.		12685	60/65.5
2	Machined By		V.T.C M/c Shop	Drg No- LSD 902
3	Pallet Die No.		11367 (12.0mm)	(REV00)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	641.7mm	Step od-652.1mm
6	Inside Diameter	Drg. No.	508.8mm	ID Step-520.1/539.1mm
7	Width of Pellet Die	Drg. No.	175mm	Taper-8°
8	Grooves as per Drawing	Drg. No.	30 X 21 X 9mm / 25 X 9mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 4
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		574mm	
13	Tapping Hole Diameter		M16 check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	1 Side Tapping 2nd Side Slot	
15	Tapping Hole Depth		Drill Depth-30.4mm Tapping Depth-28.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanbreet Singh 26/09/24

4 Slot 51.5mm

1	As per programme no.		—	long 28mm width
2	Gun Drilling Work Completed On		—	15mm Deep
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-5
2	External Relief Dia	12.5mm	All Rows					
3	External Relief Depth		5.5mm					
4	Inspection Done Before Hardening By (Name)		Ramanbreet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		27	09	24			

Inspected By (Sign) & Date

Ramanbreet Singh 27/09/24

[Signature]
27/9/24

Reviewed by (Engineer-CNC)

Manager-QA