



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.		12685 ✓	60/65.5 ✓
2	Machined By		V.T.L Mic Shop	Drg No - USD 907
3	Pallet Die No.		11159 (12.0mm)	CREV 00 ✓
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	641.7mm ✓	Step ad - 652.1mm ✓
6	Inside Diameter	Drg. No.	508.1mm ID Step - 520.1mm / 539.7mm ✓	Step length - 32mm ✓
7	Width of Pellet Die	Drg. No.	175mm ✓	Tapler - 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		Mic 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 8 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 Ramanpreet Singh 28/09/24 4 Slot 51.5mm

1	As per programme no.		—	Long 28mm
2	Gun Drilling Work Completed On		—	Width 15mm Peel
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°
Pow - 5 ✓

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	12.5mm ✓	Allow						
3	External Relief Depth		5.5mm ✓						
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		28	09	24				

Inspected By (Sign) & Date Ramanpreet Singh 28/09/24

[Signature]
Reviewed by (Engineer-CNC)

Manager-QA