



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.			
2	Machined By		13298 ✓	28/50
3	Pallet Die No.		V.T-2 M/c Shop	Drg No - CSD 9980
4	Die Category	Drg. No.	13386 (3.0mm)	(Rev 00)
5	Out Side Diameter	Drg. No.	SEW	
6	Inside Diameter	Drg. No.	63mm	Step length 18.5mm
7	Width of Pellet Die	Drg. No.	570.12mm	
8	Grooves as per Drawing	Drg. No.	222mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13X8X5mm / 13X8X5mm	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 12 Both side]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm ✓	
13	Tapping Hole Diameter		M20 check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth - 20.4mm Tapping depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 16/11/24

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					
2	External Relief Dia	3.5mm	outside (3.3)	Inner			
3	External Relief Depth		25mm	22mm			
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		16	11	24		

Inspected By (Sign) & Date

Ramanjeet Singh 16/11/24

Reviewed by (Engineer-CNC)

Manager-QA