



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.		11905	33/46
2	Machined By		V.T.L M/C SHOP	Drg No- LSD/041
3	Pallet Die No.		11745 (3.0mm)	(Revo)
4	Die Category	Drg. No.	JW102	
5	Out Side Diameter	Drg. No.	410mm Step on 384	Step length-10.5
6	Inside Diameter	Drg. No.	315.12 mm / 318.12 mm	Maintain
7	Width of Pellet Die	Drg. No.	134mm	in final M/cing
8	Grooves as per Drawing	Drg. No.	4 x 5 = 3 mm / 4 x 5 = 3 mm	
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		350mm	
13	Tapping Hole Diameter		1/2" check by 1/2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth- 16.7 Tapping Depth- 14.8 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ramanpreet Singh 29/5/24	
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-68				
1	Counter Sinking Depth & Finish	ok		Row-22
2	External Relief Dia	3.5mm	outside (2-2) Inner	
3	External Relief Depth		19mm 13mm	
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		29	5
Inspected By (Sign) & Date			Ramanpreet Singh 29/5/24	

Reviewed by (Engineer-CNC)

Manager-QA