



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.		19073	33/40
2	Machined By		V.T.L M/C SHOP	Drg No - LEC-15061
3	Pallet Die No.		11818 (2.8mm)	CRCV00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm Step dia 499mm	Tapping 12°
6	Inside Diameter	Drg. No.	42.12mm	Step length = 8mm
7	Width of Pellet Die	Drg. No.	153mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of
10	Drilling Area Surface Smoothness		ok	Holes 2
11	Tapping Operator		M/C SHOP	Both Side
12	Tapping PCD		454mm	
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 - 18.6 Tapping Depth - 16.7mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet 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 60°

1	Counter Sinking Depth & Finish	ok							Row - 26
2	External Relief Dia	31mm	outside (2-2)	2mm					
3	External Relief Depth		13mm	7mm					
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		29	5	24				

Inspected By (Sign) & Date

Ramanjeet Singh 29/5/24

Satyam 29/5/24

Reviewed by (Engineer-CNC)

Manager-QA