



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.			
2	Machined By		12048 ✓	40/55 ✓
3	Pallet Die No.		V.T.L M/C Shop	Drg No - LSD 1061
4	Die Category	Drg. No.	R638 (80mm) ✓	(REV00) ✓
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	425mm ✓	Step od - 388mm ✓
7	Width of Pellet Die	Drg. No.	315.12mm / 315.5mm ⊕	Step Length - 9.5mm ✓
8	Grooves as per Drawing	Drg. No.	145mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	8X8X3mm / 8X8X3mm ✓	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8 Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		360mm / 355mm ✓	
14	Tapping On Second Side	Half pitch of 1st side	M/R check by 3/4 Bolt ✓	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.4mm Tapping Depth - 18.5mm ✓	
17	Visual Inspection Before Gun Drilling		Yes	

Inspected By (Sign) & Date Ramankreet Singh 14/06/24

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

1	Counter Sinking Depth & Finish	ok					Counter - 60° ✓
2	External Relief Dia	8.5mm ✓	outside (9-2)	Inner			Roll-11
3	External Relief Depth		23mm ✓	15mm ✓			
4	Inspection Done Before Hardening By (Name)		Ramankreet Singh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		14	06	24		

Inspected By (Sign) & Date Ramankreet Singh 14/06/24

Reviewed by (Engineer-CNC) *Satyam* 14/06/24

Manager-QA