



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7671

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		12048	30/45
3	Pallet Die No.		V.T.L M/C Shop	Drg No - LSP 1060
4	Die Category	Drg. No.	12639 (4.0mm)	CRV00
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	405mm, Step od - 388mm	Step Length - 9.5mm
7	Width of Pellet Die	Drg. No.	315.12mm / 315.5mm (P)	
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		M/C Shop	
12	Tapping PCD		360mm / 355mm	
13	Tapping Hole Diameter		M12 check by 1/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.5mm Tapping Depth - 18.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date *Ramanjeet 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 *Counter - 60° Row - 18*

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	4.5mm	Outside (2-2)	Inner				
3	External Relief Depth		19mm	15mm				
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		14	06	24			

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

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

Manager-QA