



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.		12094	28/45
2	Machined By		V.T.L M/c Shop	Drg No-LSD 813
3	Pallet Die No.		11790 (8.8mm)	(Roo)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	405mm	Step length - 9.5mm
6	Inside Diameter	Drg. No.	Step of - 389mm	
7	Width of Pellet Die	Drg. No.	315.12mm	
8	Grooves as per Drawing	Drg. No.	145mm	
9	Fitting Sizes on CNC Plate	Drg. No.	16 X 8 X 3mm / 16 X 8 X 3mm	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8]
11	Tapping Operator		ok	
12	Tapping PCD		M/c Shop	
13	Tapping Hole Diameter		358mm	
14	Tapping On Second Side	Half pitch of 1st side	3/4 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	
			ok	

Inspected By (Sign) & Date Ramanpreet Singh 15/06/24

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°

1	Counter Sinking Depth & Finish	ok							Row - 21
2	External Relief Dia	3.3mm	outside (2-2)	Inner					
3	External Relief Depth		20mm	17mm					
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		15	06	24				

Inspected By (Sign) & Date Ramanpreet Singh 15/06/24

Reviewed by (Engineer-CNC)

Manager-QA