



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.		12134 ✓	45/55 ✓
2	Machined By		V.T.L M/C Shop	Dr No - LSD 355
3	Pallet Die No.		11901 (8.0mm)	(REV00)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	629.9mm, Step of- 612mm	Step length- 20mm
6	Inside Diameter	Drg. No.	520.12mm ✓	
7	Width of Pellet Die	Drg. No.	186mm ✓	
8	Grooves as per Drawing	Drg. No.	13X8X3mm / 13X8X3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	[Tapping No. of Holes 12 Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565mm ✓	
13	Tapping Hole Diameter		M 20 check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	
15	Tapping Hole Depth		Drill Depth - 20.6mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanjeet 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 - 14
2	External Relief Dia	8.5mm ✓	outside (3-3)	Inner					
3	External Relief Depth		18mm	10mm					
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		15	06	24				

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

Reviewed by (Engineer-CNC)

Manager-QA