



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.		12174	40/50/60
2	Machined By		V.T.L MIC Shop	Drg No-LSD 727
3	Pallet Die No.		12434 (40mm)	CREVOO
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm	Step od- 792mm
6	Inside Diameter	Drg. No.	660-12mm	Step length- 28.5mm
7	Width of Pellet Die	Drg. No.	324mm	Undercut- 6mm
8	Grooves as per Drawing	Drg. No.	21.5 X 8 X 8mm / 21.5 X 8 X 8mm	
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		MIC Shop	
12	Tapping PCD		725mm	
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- 31.4mm Tapping Depth- 29.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanpreet Singh 21/06/24	
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 6 Hole close	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Row-47
2	External Relief Dia	4.5mm, 5.0mm	4.5mm 5.0mm	
3	External Relief Depth		20mm 10mm	All Rows
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		21 06 24	
Inspected By (Sign) & Date			Ramanpreet Singh 21/06/24	

Reviewed by (Engineer-CNC) *Satya 21/6/24*

Manager-QA