



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.		12193	27/40
2	Machined By		V.T.L M/C Shop	Drg No- LSD 782
3	Pallet Die No.		12729 (3.0mm)	(Rev 00)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500mm Step OD- 491mm	Step length- 17mm
6	Inside Diameter	Drg. No.	420.12mm	
7	Width of Pellet Die	Drg. No.	182mm	
8	Grooves as per Drawing	Drg. No.	10 X 10 X 5mm / 10 X 10 X 5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 8 Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		455mm	
13	Tapping Hole Diameter		3/4" check by 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth- 19.4mm Tapping Depth- 17.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanjeet Singh 20/06/24

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	3.3mm	outside (7-7)	Inner				Row-30
3	External Relief Depth		16mm	13mm				
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		20	06	24			

Inspected By (Sign) & Date Ramanjeet Singh 20/06/24

Satyam
20/06/24

Reviewed by (Engineer-CNC)

Manager-QA