



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.		12096	48/50
2	Machined By		V.T.L M/c Shop	Drg No - LSD 1004
3	Pallet Die No.		12844 (6.0mm)	(REV 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9mm, Step od - 491.5mm	Step length - 17.5mm
6	Inside Diameter	Drg. No.	420.12mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12X8X3mm / 12X8X3mm	
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		456mm	
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 - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 24/06/24

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-bor

1	Counter Sinking Depth & Finish	OK								Row - 15
2	External Relief Dia	6.5mm	outside (P-2)	Innet						
3	External Relief Depth		8mm	2mm						
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		24	06	24					

Inspected By (Sign) & Date

Ramanpreet Singh 24/06/24

Reviewed by (Engineer-CNC)

Satyam 24/06/24

Manager-QA