



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.		12214	48/50
2	Machined By		V.T.L M/C Shop	Drg No - LSD289
3	Pallet Die No.		12603 (4.0mm)	(CRV00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620.1mm Step of - 622.6mm	Step length - 19.5mm
6	Inside Diameter	Drg. No.	520.12mm	Undercut - 1.4mm
7	Width of Pellet Die	Drg. No.	222mm	Taper - 12°
8	Grooves as per Drawing	Drg. No.	14 X 8 X 5mm / 14 X 8 X 5mm	
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 M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 22.3mm Tapping Depth - 20.4mm	
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 - 60° Row - 31

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	4.5mm	outside (3-3)	Inner				
3	External Relief Depth		10mm	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

Satyam 24/6/24

Reviewed by (Engineer-CNC)

Manager-QA