



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.		12098	36/40
2	Machined By		V.T.C M/C SHOP	Drg No - Lark Std
3	Pallet Die No.		11504 (4.0mm)	9109
4	Die Category	Drg. No.	Junior	✓
5	Out Side Diameter	Drg. No.	399.9mm, Step od - 394.8mm	Step Length - 14.5mm
6	Inside Diameter	Drg. No.	320.12mm	✓
7	Width of Pellet Die	Drg. No.	142mm	
8	Grooves as per Drawing	Drg. No.	15.5 X 7 X 2mm / 15.5 X 7 X 2mm	
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		355mm	✓
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 21.5mm Tapping Depth - 19.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanjeet Singh 27/06/24

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 - 17

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5mm	outside (2-2)	Inner			
3	External Relief Depth		8mm	4mm			
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		27	06	24		

Inspected By (Sign) & Date Ramanjeet Singh 27/06/24

[Signature]
27/6/24

Reviewed by (Engineer-CNC)

Manager-QA