



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.		12402 ✓	35/40
2	Machined By		V.T.L Mic Shop	Drg No-2EC 15062
3	Pallet Die No.		11847 (3.5mm) ✓	(Revo)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	4997 Step OD - 498.8mm	Step Length - 18mm
6	Inside Diameter	Drg. No.	420.12mm ✓	
7	Width of Pellet Die	Drg. No.	158mm ✓	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 3 mm / 12 X 8 X 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 8
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		Mic Shop	Both side ✓
12	Tapping PCD		454mm ✓	
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 - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes	<
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 12/07/24

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°

1	Counter Sinking Depth & Finish	OK						Row-??
2	External Relief Dia	3.8mm	outside CP-??	Inner				
3	External Relief Depth		8mm	5mm				
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		12	07	24			

Inspected By (Sign) & Date

Ramanjeet Singh. 12/07/24

Signature
12/07/24

Reviewed by (Engineer-CNC)

Manager-QA