



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.		12656 ✓	45/45
2	Machined By		V.T.L M/c Shop	Drg No - LSD 541
3	Pallet Die No.		11795 (80mm)	(REV 00) ✓
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410mm	Step Length - 14.5mm
6	Inside Diameter	Drg. No.	320.12mm	Step Length - 14.5
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 - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 24/08/24

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
6029 ✓

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	8.5mm	outside CP-27	Innel				
3	External Relief Depth		8mm	0				
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	08	24			

Inspected By (Sign) & Date

Ramanpreet Singh 24/08/24

Satso 24/08/24
Reviewed by (Engineer-CNC)

Manager-QA