



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.		12682 ✓	35/40 ✓
2	Machined By		V.T.L M/c Shop	Proj No - LarkStd
3	Pallet Die No.		11399 (3.2mm)	2/95 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm ✓	Step od - 491mm
6	Inside Diameter	Drg. No.	420.12mm ✓	Step length - 17.5mm
7	Width of Pellet Die	Drg. No.	158mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes & Both side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454mm ✓	
13	Tapping Hole Diameter		M70 check by M70 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 25/08/24

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°
Pow - 23

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5mm	outside (2-2)	Inner			
3	External Relief Depth		11mm	5mm			
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		25	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 25/08/24

Reviewed by (Engineer-CNC)

Manager-QA