



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.		12682	35/40
2	Machined By		V.T.L M/c Shop	Drg No - Lark Std
3	Pallet Die No.		11803 (3.2mm)	P175
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm	Step length - 17.5mm
6	Inside Diameter	Drg. No.	Step od - 491mm	
7	Width of Pellet Die	Drg. No.	420.12mm	
8	Grooves as per Drawing	Drg. No.	158mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm / 12x8x3mm	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 8 Both Side]
11	Tapping Operator		M/c Shop	
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 Ramanpreet Singh 27/08/24

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° Row - P3

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5mm	outside (P-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	P7	08	P4			

Inspected By (Sign) & Date Ramanpreet Singh 27/08/24

Reviewed by (Engineer-CNC)

Manager-QA