



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8154

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.		12741	35/40
2	Machined By		V.T.L M/c Shop	Drg No - Lark std
3	Pallet Die No.		12733 (3.5mm)	2195
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500mm	Step length - 17.5mm
6	Inside Diameter	Drg. No.	420.12mm	
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]
10	Drilling Area Surface Smoothness		ok	Holes 8
11	Tapping Operator		M/c 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

Ramanpreet Singh 06/09/24

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 - 27

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	4.0mm	outside (9-2)	Inner		
3	External Relief Depth		8mm	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		06	09	24	

Inspected By (Sign) & Date

Ramanpreet Singh 06/09/24

Singh
06/09/24

Reviewed by (Engineer-CNC)

Manager-QA