



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.		12578	50/50
2	Machined By		V.T.L Mic Shop	Drg No - Lark Std
3	Pallet Die No.		11857 (4.0mm)	
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620mm	Step od - 612mm
6	Inside Diameter	Drg. No.	520/2mm	Step length - 19.5mm
7	Width of Pellet Die	Drg. No.	186mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 12 Both Side]
11	Tapping Operator		Mic Shop	
12	Tapping PCD		565mm	
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 - 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 13/09/24

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 - 25

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5mm	outside (3-3)	Inner			
3	External Relief Depth		5mm	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		13	09	24		

Inspected By (Sign) & Date

Ramanpreet Singh 13/09/24

Reviewed by (Engineer-CNC)

Manager-QA