



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	Specifclation	Observations	Remarks
1	Work Order No.		12711 ✓	45/45 ✓
2	Machined By		V.T.L M/c Shop	Drg No. LSP 1135
3	Pallet Die No.		13422 (6.0mm)	CreVoo ✓
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	40.5mm ✓	Step length - 9.5mm ✓
6	Inside Diameter	Drg. No.	315mm ✓	
7	Width of Pellet Die	Drg. No.	118mm ✓	
8	Grooves as per Drawing	Drg. No.	9.5 x 7 x 3mm / 9.5 x 7 x 3mm	
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		356mm ✓	
13	Tapping Hole Diameter		3/4" check by 3/4" 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 28/09/24

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
Pow - 10

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	6.5mm	outside (2-3)	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		28	09	24		

Inspected By (Sign) & Date

Ramanpreet Singh 28/09/24

Reviewed by (Engineer-CNC)

Manager-QA