



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.		13320 ✓	33/40 ✓
2	Machined By		V.T.L M/c Shop	Dwg No-15/1506P
3	Pallet Die No.		12447 (3.0mm)	(Rr100)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm ✓	Step length-18mm
6	Inside Diameter	Drg. No.	490.12mm ✓	Tapper-10°
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 8
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Both Side ✓
12	Tapping PCD		454mm ✓	
13	Tapping Hole Diameter		M20 Check by M20 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 16/11/24

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°

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5mm	outside (R-2)	Inner			
3	External Relief Depth		13mm	7mm			
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		16	11	24		

Inspected By (Sign) & Date Ramanpreet Singh 16/11/24

Satya 15/11/24

Reviewed by (Engineer-CNC)

Manager-QA