



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.		13427 ✓	35/40 ✓
2	Machined By		V.T.L M/c SHOP	Drg No- LEC 1506P
3	Pallet Die No.		12711 (3.5mm) ✓	(REV00) ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm ✓	Step length- 18mm
6	Inside Diameter	Drg. No.	420.12mm ✓	Tapper- 1°
7	Width of Pellet Die	Drg. No.	158mm ✓	
8	Grooves as per Drawing	Drg. No.	12X 8X 3mm / 12X 8 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		Ø 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 29/11/24

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	3.8mm	outside (P-P)	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		29	11	24		

Inspected By (Sign) & Date Ramanpreet Singh 29/11/24

Sats
29/11/24,
Reviewed by (Engineer-CNC)

Manager-QA