



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.		11984 ✓	35/40
2	Machined By		V.T.2 Mic Shop	Drg No-Lark Std-
3	Pallet Die No.		11683 (3.5mm) ✓	2199
4	Die Category	Drg. No.	SEW	✓
5	Out Side Diameter	Drg. No.	500mm Step OD-491mm	Step Length-17.5mm
6	Inside Diameter	Drg. No.	420.12mm ✓	
7	Width of Pellet Die	Drg. No.	182mm ✓	
8	Grooves as per Drawing	Drg. No.	12X8X3mm / 12X8X3mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes & Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		Mic Shop	
12	Tapping PCD		454mm ✓	
13	Tapping Hole Diameter		M70 check by M70 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth-19.8mm Tapping Depth-17.3mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 21/5/24

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							Row-27
2	External Relief Dia	4.0mm	outside (3-3)	Innee					
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		21	5	24				

Inspected By (Sign) & Date Ramanpreet Singh 21/5/24

Satyam 21/5/24

Reviewed by (Engineer-CNC)

Manager-QA