



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.		11905 ✓	40/46
2	Machined By		V.T.L Mic Shop	Drg No- LSD-975
3	Pallet Die No.		11747 (40mm) ✓	(Ro)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410mm Stepod-333mm ✓	Step Depth-10.5mm
6	Inside Diameter	Drg. No.	315.12mm / 318.12mm →	maintain in
7	Width of Pellet Die	Drg. No.	108mm	after Hard m/cing
8	Grooves as per Drawing	Drg. No.	4x5x3mm / 4x5x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of]
10	Drilling Area Surface Smoothness		ok	Holes 8
11	Tapping Operator		Mic Shop	Both Side
12	Tapping PCD		350mm	
13	Tapping Hole Diameter		1/2 Check by 1/2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth-13mm Tapping Depth-10.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 28/5/24

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-15
2	External Relief Dia	4.5mm	outside (2.2)	Inner					
3	External Relief Depth		10mm	6mm					
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	5	24				

Inspected By (Sign) & Date Ramanpreet Singh 28/5/24

Satya
28/5/24

Reviewed by (Engineer-CNC)

Manager-QA