



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.		11911 ✓	33/40
2	Machined By		V.T.L M/C Shop	Drg No - 25D 977
3	Pallet Die No.		11812 (3.0mm) ✓	(Revol)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm ✓ Set = 400, 492	Step Length - 13.5
6	Inside Diameter	Drg. No.	42.12 mm ✓	
7	Width of Pellet Die	Drg. No.	152 mm ✓	
8	Grooves as per Drawing	Drg. No.	11x5x3 mm / 11x5x3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of]
10	Drilling Area Surface Smoothness		OK	Holes 8
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		456 mm ✓	✓
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 - 17 mm, Tapping Depth - 14.8 mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 29/5/24

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-24
2	External Relief Dia	3.5 mm	outside (2-2)	Inner						
3	External Relief Depth		14 mm	8 mm						
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	5	24					

Inspected By (Sign) & Date

Ramanpreet Singh 29/5/24

Signature
29/5/24

Reviewed by (Engineer-CNC)

Manager-QA