



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		12524 ✓	37/40
2	Machined By		V.T.L M/C Shop	Drg No-LEC 15062
3	Pallet Die No.		11320 (3.5mm) ✓	Creval
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H.H. Step 00-498.8	Step length-18mm
6	Inside Diameter	Drg. No.	480.12 H.H.	Tapper 12° ✓
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 3mm / 12 X 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		454 mm ✓	
13	Tapping Hole Diameter		M 20 check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth- 18.4 H.H. Tapping Depth- 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanjeet Singh 22/07/24

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

1	Counter Sinking Depth & Finish	OK						Counter-60° Row-PP
2	External Relief Dia	4.0mm	Outside (P-2)	Inner				
3	External Relief Depth		7mm	3mm				
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		22	07	24			

Inspected By (Sign) & Date Ramanjeet Singh 22/07/24

Reviewed by (Engineer-CNC)

Manager-QA