



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.		12682	35/40
2	Machined By		V.T.L M/c Shop	Drg No - Lark Std
3	Pallet Die No.		12355 (3.2mm)	9125
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm	Step od - 491mm
6	Inside Diameter	Drg. No.	490.12mm	Step Length - 17.5mm
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 8
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454mm	Both Side
13	Tapping Hole Diameter		M to check by M to 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

Ramanjeet Singh 27/08/24

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 - 23
2	External Relief Dia	3.5mm	outside	Inner					
3	External Relief Depth		11mm	5mm					
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		27	08	24				

Inspected By (Sign) & Date

Ramanjeet Singh 27/08/24

Reviewed by (Engineer-CNC)
27/08/24

Manager-QA