



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull Road, Yamuna Nagar - 135 001 (Haryana)

3181

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.		12770	32/40
2	Machined By		V.T.L M/c Shop	Drg No - Lark Std
3	Pallet Die No.		12339 (3.5mm)	7/09
4	Die Category	Drg. No.	Juniad	
5	Out Side Diameter	Drg. No.	400mm	Step od - 395mm
6	Inside Diameter	Drg. No.	320.12mm	Step length - 14.5mm
7	Width of Pellet Die	Drg. No.	142mm	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2mm / 15.5 x 7 x 2mm	
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		355mm	
13	Tapping Hole Diameter		M 16 check by M 16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 11/09/24

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 - 603

1	Counter Sinking Depth & Finish	OK							Row - 18
2	External Relief Dia	4.0mm	outside CP-2	Inner					
3	External Relief Depth	✓	12mm	8mm					
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		11	09	24				

Inspected By (Sign) & Date

Ramanpreet Singh 11/09/24

Satya Vilas

Reviewed by (Engineer-CNC)

Manager-QA