

2024



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.		11347	40/40
2	Machined By		V. T. L. N/C Shop	Dry run Lark 3319
3	Pallet Die No.		10965 (4.5) mm	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm, Step 00, 491 mm	Step length 17.4
6	Inside Diameter	Drg. No.	480.12 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	127.8 x 3 mm 127.8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No of holes 1 Both side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M202 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19 mm Tapping Depth 17 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date *Raoi 28/7/24*

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							
2	External Relief Dia	5.0 mm	90° Side (2-2)	Inner					
3	External Relief Depth		5 mm	Null					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		28	7	24				

Inspected By (Sign) & Date *Raoi 28/7/24*

Satyam
28/7/24
Reviewed by (Engineer-CNC)

Manager-QA