



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.		12106	42/50
2	Machined By		V-T/L M/C SHOP	Drg No - LarkStd
3	Pallet Die No.		11259 (4.0mm)	6355
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	690mm Step OD - 612mm	Step Length - 19.5mm
6	Inside Diameter	Drg. No.	520.14mm (C)	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm	No of tapping Hole 12 Both Side
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C SHOP	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.9mm Tapping Depth - 18.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 26/5/24

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

1	Counter Sinking Depth & Finish	OK						Counter - 60°
2	External Relief Dia	4.5mm All Line	5.0mm All Line					Row - 31
3	External Relief Depth	18mm	8mm					
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	26	5	24				

Inspected By (Sign) & Date

Ramanjeet Singh 26/5/24

Reviewed by (Engineer-CNC)

Manager-QA