



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.		11905,	44/51
2	Machined By		V.T.L M/C SHOP	Drg No - LSP-976
3	Pallet Die No.		12266 (6.0mm),	(Revol)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520mm	step od - 492mm
6	Inside Diameter	Drg. No.	420.12mm	step length - 13.5mm
7	Width of Pellet Die	Drg. No.	152mm	
8	Grooves as per Drawing	Drg. No.	11X5X3mm / 11X5X3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8 Both side]
11	Tapping Operator		M/C SHOP	
12	Tapping PCD		456mm	
13	Tapping Hole Diameter		3/4 check by 3/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 16.8mm Tapping Depth - 14.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 27/5/24

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

Counter - 60°

1	Counter Sinking Depth & Finish	ok							Row - 15
2	External Relief Dia	6.5mm	outside (P-2)	Inner					
3	External Relief Depth		13mm	7mm					
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		27	5	24				

Inspected By (Sign) & Date

Ramanpreet Singh 27/5/24

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Reviewed by (Engineer-CNC)

Manager-QA