



Lark Engineering Company (India) Pvt. Ltd.

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

7831

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.		11872	40/40	
2	Machined By		V.T.L M/C SHOP	Drg No-Lark Std	
3	Pallet Die No.		11807 (4.5mm)	2195	
4	Die Category	Drg. No.	Senior		
5	Out Side Diameter	Drg. No.	500mm	Step length-17.5mm	
6	Inside Diameter	Drg. No.	420.12mm		
7	Width of Pellet Die	Drg. No.	158mm		
8	Grooves as per Drawing	Drg. No.	12 X 8 X 3mm / 12 X 8 X 3mm		
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No of Holes 3]	
10	Drilling Area Surface Smoothness		OK		
11	Tapping Operator		M/C SHOP	[Both Side]	
12	Tapping PCD		454mm		
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 - 13.5mm Tapping Depth - 16.5mm		
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ramanjeet Singh 13/07/24		
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° Row-18	
2	External Relief Dia	5.0mm	outside CR-3 Inner		
3	External Relief Depth		5mm 0		
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		13	07	24
Inspected By (Sign) & Date			Ramanjeet Singh 13/07/24		

Sats...
13/7/24

Reviewed by (Engineer-CNC)

Manager-QA