



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.		12136	29/40
2	Machined By		Y.T.L M/c Shop	Drg No - Lark Std
3	Pallet Die No.		11324 (3.0mm)	2195
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm	Step length - 17.5mm
6	Inside Diameter	Drg. No.	Step of - 491mm	
7	Width of Pellet Die	Drg. No.	420.14mm	
8	Grooves as per Drawing	Drg. No.	158mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm / 12x8x3mm	
10	Drilling Area Surface Smoothness	Drg. No.	ok	[Tapping No. of Holes 8 Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		M/c Shop	
13	Tapping Hole Diameter		454mm	
14	Tapping On Second Side	Half pitch of 1st side	M20 check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 18.5mm Tapping Depth - 16.5mm	
17	Visual Inspection Before Gun Drilling		Yes	

Inspected By (Sign) & Date

Ramanjeet Singh 18/06/24

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 6 Hole close

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 60°
Row - 24

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	3.5mm	outside (P-2)	Inner		
3	External Relief Depth		14mm	11mm		
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		18	06	24	

Inspected By (Sign) & Date

Ramanjeet Singh 18/06/24

Sets
18/06/24

Reviewed by (Engineer-CNC)

Manager-QA