



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.		12213	29/50
2	Machined By		V.T.L M/C Shop	Drg No - Lark Std
3	Pallet Die No.		12094 (3.5mm)	1355
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm	Step od - 612mm
6	Inside Diameter	Drg. No.	520.12mm	Step Length - 19.5mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5mm / 13 X 8 X 5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 12 Both Side]
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 - 20.5mm Tapping Delta - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 15/06/24

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	

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

Counter - 60°

1	Counter Sinking Depth & Finish	ok								Row - 35
2	External Relief Dia	4.0 mm	Outside (3-3)	Inner						
3	External Relief Depth		24mm	21mm						
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		15	06	24					

Inspected By (Sign) & Date

Ramanjeet Singh 15/06/24

Satya 15/6/24

Reviewed by (Engineer-CNC)

Manager-QA