



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.		12390	36/40
2	Machined By		V.T.L M/C Shop	Drg No-LEC 15067
3	Pallet Die No.		11827 (4.0mm)	(REV00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm Step OD-498.8mm	Step length-18mm
6	Inside Diameter	Drg. No.	420.12mm	Tapper-12°
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12X8X3mm / 12X8X3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 8 Both side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
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-18.4mm Tapping Depth-16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 06/07/24

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

Counter-60 Row-20

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.3mm	outside (2-2)	Inner			
3	External Relief Depth		8mm	4mm			
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		06	07	24		

Inspected By (Sign) & Date

Ramanjeet Singh 06/07/24

Reviewed by (Engineer-CNC)

Manager-QA