



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

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12393	43/50
2	Machined By		V.T.L M/C SHOP	Drg No-LEC 9280
3	Pallet Die No.		12172 (4.5mm)	(KEX00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620 mm	Step of Tapper 12°
6	Inside Diameter	Drg. No.	520.12 mm	Step Length-18.5mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No-of Holes 12 Both Side
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 - 20.4 mm Tapping Depth - 18.5mm	
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				
1	Counter Sinking Depth & Finish	OK		Counter - 60 Row - 29
2	External Relief Dia	5.0mm	outside (3-3) Inner	
3	External Relief Depth		12mm, 7mm	
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