



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.		12371	37/50	
2	Machined By		V.T.L M/C Shop	Drwg No - LEC 9230	
3	Pallet Die No.		12630 (35mm)	CRV00	
4	Die Category	Dr. No.	SSEW		
5	Out Side Diameter	Dr. No.	690mm	Step of Tapper 12°	
6	Inside Diameter	Dr. No.	590-12mm	Step Length - 13.5mm	
7	Width of Pellet Die	Dr. No.	297mm		
8	Grooves as per Drawing	Dr. No.	13X8X5 / 13X8X5mm		
9	Fitting Sizes on CNC Plate	Dr. 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		M 20 check by M 20 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	OK		
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 13.5mm		
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ramanpreet Singh 11/07/24		
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 - 35	
2	External Relief Dia	4.0mm	Outside 3.3 Inner 17mm 13mm		
3	External Relief Depth				
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh 11/07/24		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		11	07	24
Inspected By (Sign) & Date			Ramanpreet Singh 11/07/24		

Reviewed by (Engineer-CNC)

Manager-QA