



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.		12428	40/50
2	Machined By		V.T.L M/C Shop	Drg No - LEC 12501
3	Pallet Die No.		12537 (3.8mm)	CREV 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700mm	Step OD - 693mm
6	Inside Diameter	Drg. No.	600.12mm	Step Length - 20mm
7	Width of Pellet Die	Drg. No.	222mm	Taper - 12°
8	Grooves as per Drawing	Drg. No.	12X8X7mm / 12X8X7mm	
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		640mm	
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 - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 22/07/24

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 - 6°

1	Counter Sinking Depth & Finish	OK						Row - 33
2	External Relief Dia	4.3mm	outside (3-3)	Inner				
3	External Relief Depth	/	14mm	10mm				
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		22	07	24			

Inspected By (Sign) & Date

Ramanjeet Singh 22/07/24

Sasouli 22/7/24

Reviewed by (Engineer-CNC)

Manager-QA