



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.		12418	36/45/50
2	Machined By		V.T.L M/C Shop	Drg No - LP 259
3	Pallet Die No.		12632 (4.0mm)	(REV00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620.44, 8+ep 0.0, 622.44	step length - 18
6	Inside Diameter	Drg. No.	520.12	Tapper - 12°
7	Width of Pellet Die	Drg. No.	992mm	Under cut, 1.2
8	Grooves as per Drawing	Drg. No.	12.6 x 8 x 5.44 12.7 x 8 x 5.44	
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 - 20.44 Tapping Depth - 18.544	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 20/07/24

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 - 31

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	4.5mm, 5.0mm	4.5mm	5.0mm		
3	External Relief Depth		14mm	All Rows	5mm	
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		20	07	24	

Inspected By (Sign) & Date

Ramanpreet Singh 20/07/24

Sethi 22/7/24

Reviewed by (Engineer-CNC)

Manager-QA