



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.		12445	45/50
2	Machined By		V.T.L M/C Shop	Drg No-LEC12501
3	Pallet Die No.		12541 (3.8mm)	(REV01)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700mm Stepod- 693mm	Step length- 20mm
6	Inside Diameter	Drg. No.	600.12mm	Tapper- 12°
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 7mm / 12 X 8 X 7mm	
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

Ramanpreet Singh 24/07/24

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 / Hole close

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter-61

1	Counter Sinking Depth & Finish	OK							Row- 33
2	External Relief Dia	4.3mm	Outside (3-3)	Inner					
3	External Relief Depth		9mm	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		24	07	24				

Inspected By (Sign) & Date

Ramanpreet Singh 24/07/24

Satguru 24/7/24

Reviewed by (Engineer-CNC)

Manager-QA