



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7893

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.		12454 12454	33/40
2	Machined By		V.T.L M/c Shop	Drg No - LEC 15062
3	Pallet Die No.		11851 (30mm)	CREV 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm, Step od - 498.8mm	Step length - 18mm
6	Inside Diameter	Drg. No.	420.12mm	Tapper - 12°
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 8 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454mm	
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 - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 25/07/24

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°

1	Counter Sinking Depth & Finish	OK						Row - 24
2	External Relief Dia	3.5mm	outside (2-3)	Inner				
3	External Relief Depth		13mm	7mm				
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		25	07	24			

Inspected By (Sign) & Date

Ramanpreet Singh 25/07/24

Satya 25/7/24

Reviewed by (Engineer-CNC)

Manager-QA