

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12441	32/50
2	Machined By		V.T.L M/C SHOP	Des No- LSD 633
3	Pallet Die No.		12189 (3.8mm)	(Rev 01)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	6.80mm, Step 002 6.83.4mm	Step length - 20mm
6	Inside Diameter	Drg. No.	5.80.12mm	Tapper 12°
7	Width of Pellet Die	Drg. No.	186mm	Under cut = 1.7mm
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 12]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C SHOP	Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M16 Check by M16 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 27/07/24

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 - 26
2	External Relief Dia	4.3mm	outside (3-3)	Inner					
3	External Relief Depth		21mm	18mm					
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		27	07	24				

Inspected By (Sign) & Date

Ramanjeet Singh 27/07/24

Reviewed by (Engineer-CNC)

Manager-QA