



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.		12439	40/50
2	Machined By		V.T.L M/c Shop	Drg No - LEC 10295
3	Pallet Die No.		12503 (3.0mm)	CREVOR?
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	682mm	Step of Taper-12°
6	Inside Diameter	Drg. No.	520.12mm	Step Length-32mm
7	Width of Pellet Die	Drg. No.	266mm	
8	Grooves as per Drawing	Drg. No.	28.5 X 6 X 12mm / 28.5 X 6 X 12mm	
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		630mm	
13	Tapping Hole Diameter		M 16 check by M 16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 25.3mm Tapping Depth - 23.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 12/08/24

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-42
2	External Relief Dia	3.5mm	outside (3-3)	Inner					
3	External Relief Depth		16mm	10mm					
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		12	08	24				

Inspected By (Sign) & Date

Ramanpreet Singh 19/08/24

Satish 12/8/24

Reviewed by (Engineer-CNC)

Manager-QA