



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.		1247L	40/48/55
2	Machined By		V.T.L M/c Shop	Req No - LSD 666
3	Pallet Die No.		12202 (6.0mm)	CREV00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710mm	Step length - 20mm
6	Inside Diameter	Drg. No.	600.12mm	Taper - 18°
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	12 X 10 X 7.5mm / 12 X 10 X 7.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 12 Both Side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		640mm	
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 - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 14/08/24

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							
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm	All Rows				
3	External Relief Depth		15mm	7mm					
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		14	08	24				

Inspected By (Sign) & Date

Ramanjeet Singh 14/08/24

Satya 14/8/24

Reviewed by (Engineer-CNC)

Manager-QA