



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.		12563	34/47
2	Machined By		V.T.L M/c Shop	Drp No - 156-7767
3	Pallet Die No.		12814 (3.2mm)	(Key)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	614 mm Steel - 6.22-3mm	Steel length - 18mm
6	Inside Diameter	Drg. No.	520.12mm	Tapper - 12°
7	Width of Pellet Die	Drg. No.	222mm	Under cut - 4.15mm
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5 mm / 13 X 8 X 5 mm	
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		565mm	
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

Ramanpreet 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								Row-37
2	External Relief Dia	3.8mm	Outside (3-3)	Inner						
3	External Relief Depth		17mm	13mm						
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		14	08	24					

Inspected By (Sign) & Date

Ramanpreet Singh 14/08/24

Signature

Reviewed by (Engineer-CNC)

Manager-QA