



Lark Engineering Company (India) Pvt. Ltd.

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

8015

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.		12383 ✓	60/67.5mm
2	Machined By		V.T.L M/c Shop	Des No - LSD 1092
3	Pallet Die No.		12962 (10.0mm)	CREV 00)
4	Die Category	Drg. No.	M. Jumbo ✓	✓
5	Out Side Diameter	Drg. No.	73544 ✓	Step length - 70mm
6	Inside Diameter	Drg. No.	600.1444 ✓	Taps = 12
7	Width of Pellet Die	Drg. No.	222mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x7mm / 12x8x7mm	
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		640mm ✓	
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 - 20.44 Tapping Depth - 18.544	
16	Perpendicularity of Tapped Hole		Yes	✓
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 21/08/24

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 - 13
2	External Relief Dia	10-5 mm	outside (3-3)	Inner					
3	External Relief Depth		12mm	7.5mm					
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		21	08	24				

Inspected By (Sign) & Date

Ramanpreet Singh 21/08/24

Signature
21/8/24

Reviewed by (Engineer-CNC)

Manager-QA