



Lark Engineering Company (India) Pvt. Ltd.

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

8017

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.		R654 ✓	38/50
2	Machined By		V.T.L M/c Shop	Drg No - LSD R501
3	Pallet Die No.		R497 (4.0mm)	(Revol)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H4	Step length - 90mm
6	Inside Diameter	Drg. No.	Geo. 14 H4	Tapper 12°
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 7mm / 12 X 8 X 7mm	
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		M 20 check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet 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 - 1 Hole Closed	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter-60°

1	Counter Sinking Depth & Finish	OK							Row-32 ✓
2	External Relief Dia	4.5mm	outside (33)	Inner					
3	External Relief Depth		16mm	12mm					
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		21	08	24				

Inspected By (Sign) & Date

Ramanjeet Singh 21/08/24

Reviewed by (Engineer-CNC)

Manager-QA