



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.		1966P ✓	42/55 ✓
2	Machined By		V.T.C M/c Shop	Drg No - LSD 355
3	Pallet Die No.		11900 (4.0mm) ✓	(Rev 00) ✓
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630mm ✓	Step Length - 20mm ✓
6	Inside Diameter	Drg. No.	Step of 612mm ✓	
7	Width of Pellet Die	Drg. No.	520.12mm ✓	
8	Grooves as per Drawing	Drg. No.	186mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3mm / 13x8x3mm ✓	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 12 Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		M/c Shop	
13	Tapping Hole Diameter		565mm ✓	✓
14	Tapping On Second Side	Half pitch of 1st side	M20 check by M20 Bolt ✓	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
17	Visual Inspection Before Gun Drilling		Yes	✓
			ok	

Inspected By (Sign) & Date

Ramanpreet Singh 30/08/24

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 close	

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

Counter - 60°

1	Counter Sinking Depth & Finish	ok							Row - P5
2	External Relief Dia	4.5mm	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		30	08	24				

Inspected By (Sign) & Date

Ramanpreet Singh 30/08/24

Signature
30/08/24

Reviewed by (Engineer-CNC)

Manager-QA