



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.		1P793	40/50
2	Machined By		V-T-L M/C Shop	Drg No - LEC 9980
3	Pallet Die No.		1P168 (4.0mm)	(Revoo)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	6 ϕ 0mm	Step length - 18.5mm
6	Inside Diameter	Drg. No.	5 ϕ 0.1 ϕ mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 1 ϕ Both side]
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M ϕ 0 check by M ϕ 0 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 27/08/24

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° Row - 31

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5mm	outside (3-3)	Inner			
3	External Relief Depth		17mm	10mm			
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		27	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 27/08/24

27/08/24

Reviewed by (Engineer-CNC)

Manager-QA