



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.		12621	45/45
2	Machined By		V.T.L M/c Shop	Dwg No - LEC14947
3	Pallet Die No.		12082 (5.0mm)	(Rev 00)
4	Die Category	Drg. No.	Series	
5	Out Side Diameter	Drg. No.	510mm	Step length - 17.5mm
6	Inside Diameter	Drg. No.	Step od - 491mm	
7	Width of Pellet Die	Drg. No.	490.12mm	
8	Grooves as per Drawing	Drg. No.	158mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm / 12x8x3mm	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 8 Both Side
11	Tapping Operator		ok	
12	Tapping PCD		M/c Shop	
13	Tapping Hole Diameter		454mm	
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 - 18.4mm Tapping Depth - 16.5mm	
17	Visual Inspection Before Gun Drilling		Yes	

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 / Hole close

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

1	Counter Sinking Depth & Finish	ok					Counter-60°
2	External Relief Dia	5.3mm	outside (P-2)	Inner			Row-17
3	External Relief Depth		5mm	0			
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

Satya
30/8/24

Reviewed by (Engineer-CNC)

Manager-QA