



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.			
2	Machined By		12872	33/40
3	Pallet Die No.		V.T.L M/c Shop	Drg No. LEC 15062
4	Die Category	Drg. No.	12445 (30mm)	(REV00)
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 mm Step on 498.8	Step length - 18mm
7	Width of Pellet Die	Drg. No.	42.12 mm	Tapper - 12°
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 12 Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		M/c Shop	
13	Tapping Hole Diameter		4.54mm	
14	Tapping On Second Side	Half pitch of 1st side	M 20 check by M 20 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 14/09/24

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 - 2 Hole Closed

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	3.3mm	outside CP-P	Inner				POW-24
3	External Relief Depth		13mm	7mm				
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		14	09	24			

Inspected By (Sign) & Date

Ramanpreet Singh 14/09/24

Signature
14/09/24

Reviewed by (Engineer-CNC)

Manager-QA