



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.		12824 ✓	32/50 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 114/
3	Pallet Die No.		11861 (4.0mm) ✓	(Rev00)
4	Die Category	Drg. No.	SSSTD	✓
5	Out Side Diameter	Drg. No.	620 H-H Step 00. 623.14 ✓	Step length - 20mm
6	Inside Diameter	Drg. No.	520.12 H-H ✓	Tapper - 12°
7	Width of Pellet Die	Drg. No.	186mm ✓	Under cut - 1.5mm ✓
8	Grooves as per Drawing	Drg. No.	13X8X3mm / 13X8X3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes] Both Side ✓
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm ✓	
13	Tapping Hole Diameter		M20 check by M20 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 13/09/24

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

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

Counter - 60

1	Counter Sinking Depth & Finish	OK							Row - 25
2	External Relief Dia	4.5mm	outside (3-3)	Inner					
3	External Relief Depth		22mm	18mm					
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		13	09	24				

Inspected By (Sign) & Date

Ramanpreet Singh 13/09/24

Reviewed by (Engineer-CNC)

Manager-QA