



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.		13398	40/40
2	Machined By		V.T.L M/c Sbol	Drg No - 1506P/00
3	Pallet Die No.		11830 (4.0mm)	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm	Step op - 498.88mm
6	Inside Diameter	Drg. No.	420 12mm	Step length - 18mm
7	Width of Pellet Die	Drg. No.	158mm	Tapper - 12°
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
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 Sbol	
12	Tapping PCD		454mm	
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 - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 16/11/24

1	As per programme no.			Convert Tapper
2	Gun Drilling Work Completed On			to St. After
3	Hole Finish In Gun Drilling	Marked	ok	Hand
4	Defective Holes (If Any)		No	

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

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.5mm	outside (???)	Inner				
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		18	11	24			

Inspected By (Sign) & Date

Ramanpreet Singh 18/11/24

Reviewed by (Engineer-CNC)

Manager-QA