



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7619

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.		11367	33/40
2	Machined By		V.T.L MIC Shop	Drg No - LEC-15062
3	Pallet Die No.		10939 (3.0mm)	Check
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm	Step length - 18mm
6	Inside Diameter	Drg. No.	Step of - 498.88mm	Taper - 12°
7	Width of Pellet Die	Drg. No.	420.12mm	
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		MIC Shop	
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 - 18.8mm Tapping Depth - 16.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanjeet Singh 04/6/24

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 close (B)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 60°

1	Counter Sinking Depth & Finish	OK								Row - 24
2	External Relief Dia	3.3mm	outside (R-2)	Inner						
3	External Relief Depth		13mm	7mm						
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		04	6	24					

Inspected By (Sign) & Date Ramanjeet Singh 04/6/24

Sot... 4/6/24

Reviewed by (Engineer-CNC)

Manager-QA