

7/00



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.		11951	37/60
2	Machined By		Y.T. L M/C Shop	Reg No - LSP-654
3	Pallet Die No.		11561 (6.0mm)	(REV 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	720mm, Step od - 692mm	Step Length - 11.57mm
6	Inside Diameter	Drg. No.	600.12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	32X14X7 / 32X14X7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 12]
11	Tapping Operator		M/C Shop	[Both Side]
12	Tapping PCD		645mm	
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 - 20.7mm Tapping Depth - 18.7mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 31/5/24

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

Counted - 60° Row - 16

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	7.0mm	All Rows				
3	External Relief Depth		23mm				
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		31	5	24		

Inspected By (Sign) & Date Ramanpreet Singh 31/5/24

Satya 31/5/24

Reviewed by (Engineer-CNC)

Manager-QA