



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.		12063	36/44/50
2	Machined By		V.T.L M/C Shop	Dwg No- LEC 14805
3	Pallet Die No.		11993 (3.0mm)	(REV 02)
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	70mm Step of Tapper 12°	Step length- 17.1mm
6	Inside Diameter	Drg. No.	60.12mm	
7	Width of Pellet Die	Drg. No.	265mm	
8	Grooves as per Drawing	Drg. No.	15X8X7mm / 15X8X7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 16 Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		640mm	
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- 20.8mm Tapping Depth- 18.7mm	
16	Perpendicularity of Tapped Hole		Yes	✓
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 08/6/24

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	

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

Counter-60°

1	Counter Sinking Depth & Finish	ok							Row- 47
2	External Relief Dia		3.5mm		4.0mm	8.0mm			
3	External Relief Depth		14mm		6mm				All Rows
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		08	6	24				

Inspected By (Sign) & Date

Ramanpreet Singh 08/6/24

Reviewed by (Engineer-CNC)

Manager-QA