



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.		11898 ✓	30/77 ✓
2	Machined By		V.T.L M/C Shop	Drg No- LSD-1042
3	Pallet Die No.		12370 (6.0mm) ✓	(800) ✓
4	Die Category	Drg. No.	S. Jumbo 2200V-4X4mm	
5	Out Side Diameter	Drg. No.	1004mm ✓	Step length-45mm ✓
6	Inside Diameter	Drg. No.	Step OD-1023mm ✓	
7	Width of Pellet Die	Drg. No.	850.5mm (A) ✓	Tapper-8° ✓
8	Grooves as per Drawing	Drg. No.	266mm ✓	Under cut-3.9mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	45X6X10mm / 45X6X10mm ✓	12X10mm ✓
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 2 Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		929mm / 929.3mm ✓	Face Side ✓
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Bolt	Step 2mm Deep
15	Tapping Hole Depth		ok	Both Side ✓
16	Perpendicularity of Tapped Hole		Drill Depth-39mm Tapping Depth-34mm ✓	
17	Visual Inspection Before Gun Drilling		Yes	

Inspected By (Sign) & Date

Ramanjeet Singh 12/06/24

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

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

1	Counter Sinking Depth & Finish	ok					Counter -30°
2	External Relief Dia	7.5mm ✓					Row-18
3	External Relief Depth		47mm	All Rows ✓			
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		12	06	24		

Inspected By (Sign) & Date

Ramanjeet Singh 12/06/24

Satyam 12/06/24

Reviewed by (Engineer-CNC)

Manager-QA