



Lark Engineering Company (India) Pvt. Ltd.

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

7669

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.		12048	40/55
2	Machined By		V.T.L M/C Shop	Drg No - LSP 1061
3	Pallet Die No.		12636 (8.0mm)	(Rev 00)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	425mm	Step OD - 388mm
6	Inside Diameter	Drg. No.	315.12mm / 315.5mm	Step Length - 9.5mm
7	Width of Pellet Die	Drg. No.	145mm	
8	Grooves as per Drawing	Drg. No.	8X8X3mm / 8X8X3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 8 Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		360mm / 355mm	
13	Tapping Hole Diameter		M 12 check by 3/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 14/06/24

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-11
2	External Relief Dia	8.5mm	outside (2-2)	Inner					
3	External Relief Depth		23mm	15mm					
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		14	06	24				

Inspected By (Sign) & Date

Ramanpreet Singh 14/06/24

Satsar 14/6/24

Reviewed by (Engineer-CNC)

Manager-QA