



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.		12111	37/50
2	Machined By		V.T.L M/C Shop	Dwg No - LSP 245
3	Pallet Die No.		12415 (3.2mm)	(REV 01)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700mm	Step length - 20mm
6	Inside Diameter	Drg. No.	600.12mm	Tapper - 12°
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	14 X 8 X 7mm / 14 X 8 X 7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 12 Both side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		640mm	
13	Tapping Hole Diameter		M 20 Check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 22.4mm Tapping Depth - 20.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 22/06/24

- | | | | |
|---|--------------------------------|--------|----|
| 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-36
2	External Relief Dia	3.8mm	outside (3-3)	Inner					
3	External Relief Depth		20mm	13mm					
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		22	06	24				

Inspected By (Sign) & Date

Ramanjeet Singh 22/06/24

Satish 22/06/24

Reviewed by (Engineer-CNC)

Manager-QA