



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.		12228	39/52
2	Machined By		V.T.L M/C Shop	Drg No - LSD 549
3	Pallet Die No.		12213 (30mm)	(Rev 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	704mm	Step Length - 20mm
6	Inside Diameter	Drg. No.	Step of - 693mm	Tapper - 12°
7	Width of Pellet Die	Drg. No.	600.12mm	
8	Grooves as per Drawing	Drg. No.	222mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12X10X7.5mm / 12X10X7.5mm	
10	Drilling Area Surface Smoothness		OK	Tapping No. of
11	Tapping Operator		OK	Holes 12
12	Tapping PCD		M/C Shop	Both Side
13	Tapping Hole Diameter		640mm	
14	Tapping On Second Side	Half pitch of 1st side	M 20 Check by M 20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.4mm Tapping Depth - 18.6mm	
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Ramanpreet Singh 18/06/24

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

1	Counter Sinking Depth & Finish	OK					Counter - 60°
2	External Relief Dia	3.5mm	outside (3-3)	Inner			Row - 38
3	External Relief Depth		19mm	13mm			
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		18	06	24		

Inspected By (Sign) & Date

Ramanpreet Singh 18/06/24

Satya
18/06/24

Manager-QA

Reviewed by (Engineer-CNC)