



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.		17644	39/45
2	Machined By		V.T.L M/C SHOP	Drg No-LEC 15430
3	Pallet Die No.		1777 (3.0mm)	(Rev00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	61.0mm Step 00-61.2mm	Step length- 20mm
6	Inside Diameter	Drg. No.	52.0mm 52.14mm	Under cut 1mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm 13x8x5mm	
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		565mm	
13	Tapping Hole Diameter		420	Check by 420 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 24/08/24

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 / Hole close

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

Counter- 60 Row- 288

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5mm	outside (3-3)	Inner			
3	External Relief Depth		19mm	6mm			
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		24	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 24/08/24

[Signature]
24/8/24

Reviewed by (Engineer-CNC)

Manager-QA