

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		12624 ✓	40/50 ✓
2	Machined By		V.T.L M/c Shop	Dr# No - 22A.514
3	Pallet Die No.		1823 (3.2mm)	6355 ✓
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm ✓	Step od - 612mm ✓
6	Inside Diameter	Drg. No.	520.12mm ✓	Step Length - 19.5mm ✓
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.		
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 12
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm ✓	Both Side ✓
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 - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 29/08/24

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 2 Hole close

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

Counter - 60°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.8mm	outside (3-3)	Inner						
3	External Relief Depth		16mm	10mm						
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		28	08	24					

Inspected By (Sign) & Date

Ramanjeet Singh 28/08/24

Reviewed by (Engineer-CNC)

Manager-QA