



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.		12583 ✓	40/55 ✓
2	Machined By		V.T.L M/c Shop	Dr No - LEC 14924
3	Pallet Die No.		1256 (8.0mm) ✓	(REV00) ✓
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	630 mm, Step 002 612 mm	Step length - 17.5mm
6	Inside Diameter	Drg. No.	520.12 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
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		585mm	
13	Tapping Hole Diameter		M to check by M to Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.4 mm Tapping Depth - 18.5 mm	
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

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

Counter - 60°

Row - 18

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	8.5mm	outside (3-3)	Inner			
3	External Relief Depth		70mm	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		24	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 24/08/24

Signature 26/8/24

Reviewed by (Engineer-CNC)

Manager-QA