

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		1P78P	50/55
2	Machined By		V.T.L M/c Shop	Drg No - LSD 215
3	Pallet Die No.		1P651 (35mm)	(REV 00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	630mm Step OD - 612mm	Step length - 19.5mm
6	Inside Diameter	Drg. No.	520.14mm	
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	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 12 Both Side]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm	
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

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°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0mm	Outside (3.5)	Inner					
3	External Relief Depth		19mm	5mm					
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		07	09	24				

Inspected By (Sign) & Date

Ramanpreet Singh. 07/09/24

Satya 07/19/24

Reviewed by (Engineer-CNC)

Manager-QA