



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.		19778	50/55
2	Machined By		V.T.L M/c Shop	Drg No - LEC 14924
3	Pallet Die No.		19045	(REV00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	630 mm Step OD - 612 mm	Step length - 19.5 mm
6	Inside Diameter	Drg. No.	570.12 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13X8X5 mm / 13X8X5 mm	
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		565 mm	
13	Tapping Hole Diameter		M20 check by M20 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

Ramanjeet Singh 14/09/24

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	6.5 mm	outside (3-3)	Inner				Row - 23
3	External Relief Depth		11 mm	5 mm				
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		14	09	24			

Inspected By (Sign) & Date

Ramanjeet Singh 14/09/24

Satyam 14/9/24

Reviewed by (Engineer-CNC)

Manager-QA