



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.		19868	11/50
2	Machined By		VTL M/c Shop	Dwg No - LSP 189
3	Pallet Die No.		13094 (32mm)	(REV 00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620.44	Step length - 19.5mm
6	Inside Diameter	Drg. No.	520.14	Tapper = 12°
7	Width of Pellet Die	Drg. No.	222mm	Undercut = 135
8	Grooves as per Drawing	Drg. No.	14x8x5mm / 14x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 12]
11	Tapping Operator		M/c Shop	[Both Side]
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 - 22.4mm Tapping Depth - 20.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ramanjeet Singh 16/09/24	
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 / Hole close	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok	Counter - 60° Row - 36	
2	External Relief Dia	3.5mm	outside (3-3)	Inner
3	External Relief Depth		15mm	9mm
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		16	09
Inspected By (Sign) & Date			Ramanjeet Singh 16/09/24	

Reviewed by (Engineer-CNC)

Manager-QA