



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.		13137	32/55
2	Machined By		V.T.L. n/c Shop	Dy. No. 63.9.903
3	Pallet Die No.		12223(4.0) n/c	Rev. No.
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530mm, 3 step OD, 498.88 mm	Tappers 2
6	Inside Diameter	Drg. No.	420.12 mm	Step length 17.8
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12484 3 mm / 12784 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Tapping No. of Holes 28 Both Side]
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20, Check by M20 Bol	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 18.3 mm	Tapping Depth, 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/1/24	
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° Ravi 20
2	External Relief Dia	4.5 mm	outside (2-2)	inner
3	External Relief Depth		27 mm	23 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		4 11 24	
Inspected By (Sign) & Date			Ravi 4/1/24	

Reviewed by (Engineer-CNC)
Satyam 04/11/24

Manager-QA