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.		13248	
2	Machined By		VTL- MIC Shaf	40/50
3	Pallet Die No.		13446 (402) mm	Dgn 415A01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm, ODStep- 499 mm	Step height - 20 m
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	158 mm	Taper 12°
8	Grooves as per Drawing	Drg. No.	12X8X3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping No of
11	Tapping Operator		MIC Shaf	Holes & Both Sid
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 Cheld M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth- 18mm Tapping Depth- 165	
16	Perpendicularity of Tapped Hole		ok yes	
17	Visual Inspection Before Gun Drilling		yes ok	
	Inspected By (Sign) & Date		Sanjiv 12/11/24	
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°

1	Counter Sinking Depth & Finish	ok						Ra 20
2	External Relief Dia	445	outside		VMC			
3	External Relief Depth		14 m	(2-2)	10 m			
4	Inspection Done Before Hardening By (Name)		Sanjiv					
5	Material Sent For Hardening By (Name)		hark furnace					
6	Material Sent For Hardening On Date		12	11	24			
	Inspected By (Sign) & Date		Sanjiv 12/11/24					

Satya 12/11/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner