

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7754
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.		12226	32/55
2	Machined By		V.T.L M/c Shop	Drg No - LSD 903
3	Pallet Die No.		11888 (4.0mm)	(Rev 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530mm Step od - 498.8mm	Step Length - 18mm
6	Inside Diameter	Drg. No.	✓ 420.12mm @ ✓	Taper - 12° ✓
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	[Tapping No. of Holes 8 Both Side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454mm ✓	
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 - 18.3mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 02/07/24

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° ✓ Row - 20

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5mm	outside (P-2)	Inner			
3	External Relief Depth	✓	27mm	23mm			
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		02	07	24		

Inspected By (Sign) & Date Ramanpreet Singh 02/07/24

Reviewed by (Engineer-CNC)

Manager-QA