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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.		12312	31/40
2	Machined By		V.T.L M/c Shop	Drg No - LSD 772
3	Pallet Die No.		12765 (3.5mm)	(REV00)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	394.8mm	Step of - 383.5mm
6	Inside Diameter	Drg. No.	315.12mm	Step Length - 9.5mm
7	Width of Pellet Die	Drg. No.	126mm	
8	Grooves as per Drawing	Drg. No.	12.5 X 8 X 3mm / 12.5 X 8 X 3mm	
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		350mm	
13	Tapping Hole Diameter		MIR check by MIR Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.2mm	Tapping Depth - 18.5mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date *Ramanjeet Singh 11/07/24*

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°*

1	Counter Sinking Depth & Finish	OK							Row - 16
2	External Relief Dia	4.0mm	outside	Inner					
3	External Relief Depth		12mm	9mm					
4	Inspection Done Before Hardening By (Name)		<i>Ramanjeet Singh</i>						
5	Material Sent For Hardening By (Name)		<i>Lark Furnace</i>						
6	Material Sent For Hardening On Date		11	07	24				

Inspected By (Sign) & Date *Ramanjeet Singh 11/07/24*

Sats
11/7/24
Reviewed by (Engineer-CNC)

Manager-QA