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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.		12435 ✓	40/40
2	Machined By		V.T.L M/c Shop	Reg No- Lark Std
3	Pallet Die No.		8168 (4.0mm) ✓	2195 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm Step of- 491mm	Step Length- 17.5mm
6	Inside Diameter	Drg. No.	420.12mm ✓	
7	Width of Pellet Die	Drg. No.	158mm ✓	
8	Grooves as per Drawing	Drg. No.	12X 8 X 3mm / 12X 8 X 3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 8
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Both Side
12	Tapping PCD		454mm ✓	
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 - 18.5mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanjeet Singh 13/07/24

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							Roll - 90
2	External Relief Dia	4.3mm ✓	outside (2-2)	Inner					
3	External Relief Depth		4mm	0					
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		13	07	24				

Inspected By (Sign) & Date Ramanjeet Singh 13/07/24

Satyajit
13/7/24

Reviewed by (Engineer-CNC)

Manager-QA