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.		12358	45/50
2	Machined By		V.T.L M/C Shop	Drg No - LSP 406
3	Pallet Die No.		12629 (3.2mm)	(Rev 00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	8.20mm Step Ø - 8.22.7mm	Step Length - 13mm
6	Inside Diameter	Drg. No.	5.20.12mm	Taper - 12°
7	Width of Pellet Die	Drg. No.	2.22mm	Under Cut - 1.4mm
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5mm / 13 X 8 X 5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 12 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		5.65 mm	
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 - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ramanpreet 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 1 Hole close (A)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker — Counter - 60 Row - 37

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	3.8mm	Outside (3-3)	Inner				
3	External Relief Depth		12mm	5mm				
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		13	07	24			
	Inspected By (Sign) & Date		Ramanpreet Singh 13/07/24					

Satyam 13/7/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner