

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.		12468 ✓	33/66 ✓
2	Machined By		V.T.L Mic Shop	Drg No - LSD 609
3	Pallet Die No.		12791 (6.0mm)	CREV 01 ✓
4	Die Category	Drg. No.	M. Jumbo 2200Vc 4x3mm ✓	
5	Out Side Diameter	Drg. No.	680-7mm Step od - 693mm	Step Length - 31mm ✓
6	Inside Diameter	Drg. No.	548-12mm	Taper - 8° ✓
7	Width of Pellet Die	Drg. No.	195mm ✓	Under cut - 2.5mm ✓
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x8mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 4 Both Side] ✓
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		Mic Shop	
12	Tapping PCD		619mm ✓	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Face side step 2mm ✓
14	Tapping On Second Side	Half pitch of 1st side	OK	Deep Both Side ✓
15	Tapping Hole Depth		Drill Depth - 35mm Tapping Depth - 32mm	
16	Perpendicularity of Tapped Hole		Yes	✓
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 27/07/24

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 - 30°

1	Counter Sinking Depth & Finish	OK						Row - 12 ✓
2	External Relief Dia	7.5mm	All Rows					
3	External Relief Depth		33mm					
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		27	07	24			

Inspected By (Sign) & Date

Ramanpreet Singh 27/07/24

Satya 27/7/24

Reviewed by (Engineer-CNC)

Manager-QA