

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.		12411 ✓	33/50 ✓
2	Machined By		V.T.L Mic Shop	Dwg No-LSP 344
3	Pallet Die No.		11996 (3.0mm) ✓	(Revoo) ✓
4	Die Category	Drg. No.	MJEW	
5	Out Side Diameter	Drg. No.	700 H.H. Step OD. 692 H.H.	Step Length-17.5mm ✓
6	Inside Diameter	Drg. No.	600.12 H.H.	
7	Width of Pellet Die	Drg. No.	265mm ✓	
8	Grooves as per Drawing	Drg. No.	15 X 8 X 7mm / 15 X 8 X 7mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 16 Both Side ✓
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		Mic Shop	
12	Tapping PCD		64.0mm ✓	
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-20.3mm Tapping Depth-18.5mm ✓	
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 - 1 Hole Colused	

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter-60° Row-47

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5mm	outside (3-3)	Inner			
3	External Relief Depth		23mm	17mm			
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

Reviewed by (Engineer-CNC)
Satsar 27/7/24

Manager-QA