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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.		1P533 ✓	34/50 ✓
2	Machined By		V.T.C M/C Shop	Drg No - LSD 1101
3	Pallet Die No.		1P662 (P.8mm)	(REV00) ✓
4	Die Category	Drg. No.	Juni2	
5	Out Side Diameter	Drg. No.	403mm ✓	STEP OP - 381.7mm
6	Inside Diameter	Drg. No.	303.12mm / 304.10mm ✓	STEP length - 10.5mm ✓
7	Width of Pellet Die	Drg. No.	95mm ✓	
8	Grooves as per Drawing	Drg. No.	9x6x3mm / 9x6x3mm ✓	
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		M/C Shop ✓	
12	Tapping PCD		350mm ✓	
13	Tapping Hole Diameter		M14 check by M14 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK ✓	
15	Tapping Hole Depth		Drill Depth - 14.4mm Tapping Depth - 12.5mm ✓	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK ✓	

Inspected By (Sign) & Date Ramanpreet Singh 20/08/24

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 / Hole close (A) ✓

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 60° Row - 14

1	Counter Sinking Depth & Finish	OK ✓						
2	External Relief Dia	5.3mm ✓	outside CP-D	2mm ✓				
3	External Relief Depth		22mm ✓	16mm ✓				
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		20	08	24			

Inspected By (Sign) & Date Ramanpreet Singh 20/08/24

Satya 20/8/24
Reviewed by (Engineer-CNC)

Manager-QA