

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.		12533	44/50
2	Machined By		V.T.L M/c shop	Drg No - LSD 1101
3	Pallet Die No.		12663 (4.0mm)	CRV00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4.03mm	Step of 3.817mm
6	Inside Diameter	Drg. No.	303.12mm / 304mm	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	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 16 Both Side
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 - 17.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 16/08/24

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

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

1	Counter Sinking Depth & Finish	OK						Counter - 60°
2	External Relief Dia	4.5mm	outside	inner				Row - 11
3	External Relief Depth		17mm	6mm				
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		16	08	24			

Inspected By (Sign) & Date

Ramanpreet Singh 16/08/24

Reviewed by (Engineer-CNC)

Manager-QA