

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.		12684	44/55
2	Machined By		V.T.C M/c Shop	Drg No- LSD 453
3	Pallet Die No.		11523 (40mm)	(REV 00)
4	Die Category	Drg. No.	Jumbo EW	
5	Out Side Diameter	Drg. No.	740mm	Step length- 23mm
6	Inside Diameter	Drg. No.	620-19mm	Under wt- 1.7mm
7	Width of Pellet Die	Drg. No.	290mm	Taper- 10°
8	Grooves as per Drawing	Drg. No.	15 X 8 X 5mm / 15 X 8 X 5mm	
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		685mm	
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 - 20.5mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 17/08/24

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

Counter-60

1	Counter Sinking Depth & Finish	OK						Row- 43
2	External Relief Dia	4.5mm	outside (3-3)	Inner				
3	External Relief Depth		19mm	11mm				
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		17	08	24			

Inspected By (Sign) & Date

Ramanpreet Singh 17/08/24

Reviewed by (Engineer-CNC)

Manager-QA