

8006

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.		12577 ✓	38/40 ✓
2	Machined By		V.T.L Mic Shop	Drg No- LSD 335
3	Pallet Die No.		12184 (3.5mm)	(Rev00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm ✓	Step of 491mm ✓
6	Inside Diameter	Drg. No.	420.12mm ✓	Step Length- 17.5mm ✓
7	Width of Pellet Die	Drg. No.	158mm ✓	
8	Grooves as per Drawing	Drg. No.	12X8X3mm / 12X8X3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 8 Both Side]
11	Tapping Operator		Mic Shop	
12	Tapping PCD		454mm ✓	
13	Tapping Hole Diameter		3/4 check by 3/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK ✓	
15	Tapping Hole Depth		Drill Depth - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanjeet 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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter-60° Row-22

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.0mm ✓	outside (P-2)	Inner			
3	External Relief Depth		8mm ✓	2mm ✓			
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		20	08	24		

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

Reviewed by (Engineer-CNC)

Manager-QA