

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7998

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.			
2	Machined By		12571 ✓	21/40 ✓
3	Pallet Die No.		V.T.L M/c Shop	Drg No - LSD 21
4	Die Category	Drg. No.	12160 (P.8mm)	(Rev 02)
5	Out Side Diameter	Drg. No.	Senior	✓
6	Inside Diameter	Drg. No.	500mm Step of 499mm	Step length 17mm
7	Width of Pellet Die	Drg. No.	420.12mm	Tapper 12°
8	Grooves as per Drawing	Drg. No.	158mm	✓
9	Fitting Sizes on CNC Plate	Drg. No.	12X8X3mm / 12X8X3mm	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8]
11	Tapping Operator		ok	
12	Tapping PCD		M/c Shop	[Both Side]
13	Tapping Hole Diameter		454mm ✓	✓
14	Tapping On Second Side	Half pitch of 1st side	3/4 Check by 3/4 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 18.4mm Tapping Depth - 16.5mm	
17	Visual Inspection Before Gun Drilling		Yes	
			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

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	3.3mm	outside (P-2)	Inner						Row - 28
3	External Relief Depth		22mm	19mm						
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		Po	08	24					

Inspected By (Sign) & Date

Ramanpreet Singh 20/08/24

Reviewed by (Engineer-CNC)
20/08/24.

Manager-QA