

8071

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12617 ✓	40/40 ✓
2	Machined By		V.T.L M/C Shop	Drg No - LEC 15069
3	Pallet Die No.		12350 (4.0mm)	(REV 00)
4	Die Category	Drg. No.	Semirot	
5	Out Side Diameter	Drg. No.	500 H4 Step 00.498.88	Step length - 18mm
6	Inside Diameter	Drg. No.	420.14 H4 ✓	Taper = 12°
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	Tapping No. of Holes 8 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		454mm ✓	
13	Tapping Hole Diameter		M70 check by M70 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

Ramanpreet Singh 26/08/24

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

(counted - 60°)

1	Counter Sinking Depth & Finish	OK							Row - 20
2	External Relief Dia	4.5mm	outside (2-3)	Inner					
3	External Relief Depth		5mm	0					
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		26	08	24				

Inspected By (Sign) & Date

Ramanpreet Singh 26/08/24

Reviewed by (Engineer-CNC)
 26/08/24

Manager-QA