

8070

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.		12726 ✓	30/40 ✓
2	Machined By		V.T.L M/c Shop	Reg No - Lark Std
3	Pallet Die No.		9793 (30mm) ✓	2125 ✓
4	Die Category	Drg. No.	Senior	✓
5	Out Side Diameter	Drg. No.	50.0mm ✓	Step of - 491mm ✓
6	Inside Diameter	Drg. No.	490.19mm ✓	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	[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		M 20 check by M 20 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 1 Hole close (B)

Note : Mark the defective holes/missed holes with the help of Permanent Marker Counter - 60

1	Counter Sinking Depth & Finish	ok							Row - 24
2	External Relief Dia	3.5mm ✓	outside (P-2)	Inner					
3	External Relief Depth		13mm	10mm					
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

[Signature]
26/8/24.
Reviewed by (Engineer-CNC)

Manager-QA