

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.		19870 ✓	50/50
2	Machined By		V.T.L M/c Shop	Drg No- LSD 153
3	Pallet Die No.		13031 (8.0mm) ✓	(REV00)
4	Die Category	Drg. No.	Senior	✓
5	Out Side Diameter	Drg. No.	5 diam 3 step 0.0249 ✓	Step length-16.5mm ✓
6	Inside Diameter	Drg. No.	4.20.12 4mm ✓	
7	Width of Pellet Die	Drg. No.	160mm ✓	
8	Grooves as per Drawing	Drg. No.	12 X 9 X 3mm / 12 X 9 X 3mm ✓	
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		3/4 check by 3/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth- 20.4 Tapping Depth- 18.6 mm	
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

Counter-60

1	Counter Sinking Depth & Finish	ok							Row-19
2	External Relief Dia	8.5mm	outside (9-7)	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

[Signature]
26/8/24

Reviewed by (Engineer-CNC)

Manager-QA