

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.		12612	4-166
2	Machined By		V T L M/c Shop	Drg No - LSD 390
3	Pallet Die No.		19771 (6.0mm)	(CNC Vob) ✓
4	Die Category	Drg. No.	M-Jumbo	606 ✓
5	Out Side Diameter	Drg. No.	680.1 mm	Step length - 31 ✓
6	Inside Diameter	Drg. No.	548.12 mm	Tappet 8° ✓
7	Width of Pellet Die	Drg. No.	195.1 mm	Under cut 2.5 mm ✓
8	Grooves as per Drawing	Drg. No.	32x7x8 mm / 32x7x8 mm	(4-02) ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping Holes ✓
10	Drilling Area Surface Smoothness		ok	Holes 2 ✓
11	Tapping Operator		M/c Shop	Both Side ✓
12	Tapping PCD		619 mm	Face Side ✓
13	Tapping Hole Diameter		M16 check by M16 Bolt	Step 2 mm ✓
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side ✓
15	Tapping Hole Depth		Drill Depth - 34.4 Tapping Depth - 31.8 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	Discuss with Neeraj Sir
4	Defective Holes (If Any)		No	
<p>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</p> <p style="text-align: right;">→ Counter 30° Row-12 ✓</p>				
1	Counter Sinking Depth & Finish	ok		
2	External Relief Dia	7.0mm	All Rows	
3	External Relief Depth		26mm ✓	
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)

Manager-QA