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.		12657	43/50
2	Machined By		V.T.L M/c Shop	Drg No - LSD 976
3	Pallet Die No.		12263 (6.0mm)	(Revol)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520mm Step OD. 491.8	Step length - 13.5mm
6	Inside Diameter	Drg. No.	① 420.12 mm	
7	Width of Pellet Die	Drg. No.	152mm	
8	Grooves as per Drawing	Drg. No.	11X5X3mm / 11X5X3mm	
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		456mm	
13	Tapping Hole Diameter		Ø3/4" Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 18.4mm Tapping Depth - 14.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ramanpreet Singh 27/08/24	
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° Row-15
2	External Relief Dia	6.5mm	outside (2-2)	Inner				
3	External Relief Depth		13mm	7mm				
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		27	08	24			
	Inspected By (Sign) & Date		Ramanpreet Singh 27/08/24					

Satyam 27/8/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner