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.		18657	73/50
2	Machined By		V.T.L M/c Shop	Dwg No - LSD 976
3	Pallet Die No.		12314 (60mm)	(Revol)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm / Step of - 492 mm	Step length - 13.5mm
6	Inside Diameter	Drg. No.	(A) 480.1mm	
7	Width of Pellet Die	Drg. No.	158 mm	
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		456 mm	
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 - 16.4mm 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	Discussed with Sales for Bore oversize
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° ROW - 15

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5mm	Outside (P-P)	Innce					
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		P7	08	P4				
	Inspected By (Sign) & Date		Ramanpreet Singh 27/08/24						

Satya 27/8/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner