

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.		11987 ✓	38/50 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 978
3	Pallet Die No.		12917 (6.0mm) ✓	(Rev 01)
4	Die Category	Drg. No.	SEW ✓	
5	Out Side Diameter	Drg. No.	520 mm, Step 00-491 ✓	Step length - 19.5mm ✓
6	Inside Diameter	Drg. No.	420.12 mm ✓	
7	Width of Pellet Die	Drg. No.	182mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 8 Both Side ✓
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454mm ✓	
13	Tapping Hole Diameter		φ 3/4" check by φ 3/4" Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK ✓	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm ✓	
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

Counter-60°

1	Counter Sinking Depth & Finish	OK							Row-13
2	External Relief Dia	6.5mm	outside (P-P)	Innel					
3	External Relief Depth	✓	20mm	12mm					
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

Reviewed by (Engineer-CNC)

Manager-QA