

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.			
2	Machined By		12696 ✓ V.T.L. Mic Shop	19/66 ✓ Drg No - LSD 609
3	Pallet Die No.		12954 (60mm) ✓	(Rev 01) ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1mm ✓	Step length - 31mm ✓
6	Inside Diameter	Drg. No.	548.12mm ✓	Taper - 8 ✓
7	Width of Pellet Die	Drg. No.	195mm ✓	Under cut - 2.5mm ✓
8	Grooves as per Drawing	Drg. No.	32X7X8mm / 32X7X8mm ✓	4X8mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 4]
11	Tapping Operator		Mic Shop	[Both Side] ✓
12	Tapping PCD		619mm ✓	
13	Tapping Hole Diameter		M16 Check by M16 Bolt ✓	Face Side Step 2mm ✓
14	Tapping On Second Side	Half pitch of 1st side	ok	Deep Both Side ✓
15	Tapping Hole Depth		Drill Depth - 34mm Tapping Depth - 31.8mm ✓	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ramanpreet Singh 30/08/24	
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		Count 2-30° Row - 19
2	External Relief Dia	7.5mm	All Rows	
3	External Relief Depth	47mm		
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		30 08 24	
Inspected By (Sign) & Date			Ramanpreet Singh 30/08/24	

Reviewed by (Engineer-CNC)

Manager-QA