

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.		12768 ✓	38/45 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 422
3	Pallet Die No.		13004 (5.0mm)	(Revoo)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	51.044 ✓	Step 02. 491 ✓
6	Inside Diameter	Drg. No.	42.1244 ✓	Step Length - 17.5mm ✓
7	Width of Pellet Die	Drg. No.	182mm ✓	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 3mm / 12 X 8 X 3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8]
11	Tapping Operator		M/c Shop	[Both Side]
12	Tapping PCD		454mm ✓	✓
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 05/09/24

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 ok	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter-60° Row-2/
2	External Relief Dia	5.5mm	outside (P-P)	Inner				
3	External Relief Depth		12mm	7mm				
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		05	09	24			

Inspected By (Sign) & Date

Ramanjeet Singh 05/09/24

Reviewed by (Engineer-CNC)

Manager-QA