

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.		1P768	38/45
2	Machined By		V.T.L M/c Shop	Drg No - LSD 422
3	Pallet Die No.		13006 (5.0mm)	(REV00)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	51044 ✓ Step 02 4914 ✓	Step Length - 17.5mm ✓
6	Inside Diameter	Drg. No.	420.1244 ✓	
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	
12	Tapping PCD		454mm ✓	- Both Side ✓
13	Tapping Hole Diameter		M 20 Check by M 20 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	

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

Counter-60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	5.5mm	outside	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