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.		12853	36/40
2	Machined By		V.T.L M/c Shop	Drg No. Lark Std
3	Pallet Die No.		12340 (3.0mm)	9109
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 mm Step OD-395mm	Step Length-14.5mm
6	Inside Diameter	Drg. No.	320.12mm	
7	Width of Pellet Die	Drg. No.	14.2mm	
8	Grooves as per Drawing	Drg. No.	15.5X7X2mm / 15.5X7X2mm	
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		355mm	—
13	Tapping Hole Diameter		M16 Check by M16 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 16/09/24	
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						Row- 20
2	External Relief Dia	3.3mm	outside (PP)	Inner				
3	External Relief Depth		10mm	4mm				
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		16	09	24			
	Inspected By (Sign) & Date		RamanPreet Singh 16/09/24					

16/9/24.

Reviewed By (Engineer-CNC)

Manager-QA

Scanned with CamScanner