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.		12685 ✓	65.5 / 65.5 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 902
3	Pallet Die No.		11368 (12.0mm) ✓	CRev 00)
4	Die Category	Drg. No.	SSSTD ✓	✓
5	Out Side Diameter	Drg. No.	641.7mm ✓ Step of - 652.1mm ✓	Step Length - 32mm ✓
6	Inside Diameter	Drg. No.	508.8mm ✓ ID Step - 520.1mm ✓	539.1mm ✓
7	Width of Pellet Die	Drg. No.	175mm ✓	Taper - 8°
8	Grooves as per Drawing	Drg. No.	30 X 21 X 9mm / 25.5 X 8.5mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	Tapping No. of Holes 4
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		574mm ✓	
13	Tapping Hole Diameter		M 16 Check by M 16 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	1 Side Tapping & 2nd Side Slot ✓	
15	Tapping Hole Depth		Drill Depth - 30.4mm Tapping Depth - 28.5mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ramanpreet Singh 27/09/24	4 Slot 51.5mm
1	As per programme no.		—	long 28mm Width
2	Gun Drilling Work Completed On		—	15mm Deep ✓
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 - 5
2	External Relief Dia	No Relief	—					
3	External Relief Depth		— ✓					
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	09	24			
	Inspected By (Sign) & Date		Ramanpreet Singh 27/09/24					

Satish 27/9/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner