

8598



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.		13908	4P/50
2	Machined By		V.T.L M/c Shop	Prj No-LS031
3	Pallet Die No.		11873 (6.0mm)	(REV00)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	6.0mm / step od-623.5mm	step length-14mm
6	Inside Diameter	Drg. No.	5.20-1.2mm	angle 12°
7	Width of Pellet Die	Drg. No.	186mm	
8	Grooves as per Drawing	Drg. No.	9 X 10 X 3mm / 9 X 10 X 3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 12 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M 16 Check by M 16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth-23.4mm Tapping Depth-21.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 23/11/24

1	As per programme no.		—	Undercut=1.5mm
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

Count=60

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	φ 6.3 mm	outside (5-3)	Inner			
3	External Relief Depth		14mm	8mm			
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		23	11	24		

Inspected By (Sign) & Date Ramanpreet Singh 23/11/24

Reviewed by (Engineer-CNC) *Satish* 23/11/24

Manager-QA