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.		11966	66/66
2	Machined By		V.T.L M/C Shop	Drg No- LSD-609
3	Pallet Die No.		12477 (10.0mm)	(Rev 01)
4	Die Category	Drg. No.	M. Jumbo	OD groove - 4x3mm
5	Out Side Diameter	Drg. No.	680.7mm Step OD - 693mm	Step length - 30.6mm 1st side
6	Inside Diameter	Drg. No.	548.12mm	31mm 2nd side
7	Width of Pellet Die	Drg. No.	195mm	Under cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32X7X8mm / 32X7X8mm 4X8mm	Tapper - 8°
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 4 Both side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		619mm	Face Side Step
13	Tapping Hole Diameter		M16 Check by M16 Bolt	2mm Deep Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth — 33.1mm Tapping Depth — 31.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ramanpreet Singh 30/5/24	
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 - 8
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		30	5	24			
	Inspected By (Sign) & Date		Ramanpreet Singh 30/5/24					

Satya 30/5/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner