

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

2561
7622

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

Fin

S.No.
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S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11956 ✓	50/60 ✓
3	Pallet Die No.		V.T.L M/C Shop	Drg No - LSP 413
4	Die Category	Drg. No.	12023 (80mm)	(Revoc) ✓
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	720mm, Step od - 193mm	Step Length - 20mm
7	Width of Pellet Die	Drg. No.	600-12mm / 600-14mm (6)	Tapper - 12°
8	Grooves as per Drawing	Drg. No.	222mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	14 X 8 X 7mm / 14 X 8 X 7mm	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 12 Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		640mm ✓	
14	Tapping On Second Side	Half pitch of 1st side	M70 check by M70 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 29.3mm Tapping Depth - 20.4mm	
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

Inspected By (Sign) & Date

Ramanpreet Singh 05/6/24

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 - 18
2	External Relief Dia	8.5mm	outside (3-3) Inner	
3	External Relief Depth		15mm / 10mm	
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		05 / 6 / 24	

Inspected By (Sign) & Date

Ramanpreet Singh 05/6/24

Satya
5/6/24

Reviewed by (Engineer-CNC)

Manager-QA