

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.			
2	Machined By		1R1R5	35/45/
3	Pallet Die No.		V.T.L M/C Shop	Drg No - LSD 422
4	Die Category	Drg. No.	1R533 (5.0mm)	(Rev00) /
5	Out Side Diameter	Drg. No.	SEW	
6	Inside Diameter	Drg. No.	5/0 mm	Step of - 49/1mm
7	Width of Pellet Die	Drg. No.	420.12mm	Step length - 17.5mm
8	Grooves as per Drawing	Drg. No.	182mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12X8X3mm / 12X8X3mm	
10	Drilling Area Surface Smoothness		ok	[Tapping No of Holes & Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		454mm	
14	Tapping On Second Side	Half pitch of 1st side	M 70 Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 18.5mm Tapping Depth - 16.5mm	
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

Inspected By (Sign) & Date

Ramanpreet Singh 15/06/24

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°
Row - 21

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	5.5 mm	Outside (7-8)	Inner		
3	External Relief Depth		15 mm	10 mm		
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		15	06	24	

Inspected By (Sign) & Date

Ramanpreet Singh 15/06/24

Signature
15/06/24

Reviewed by (Engineer-CNC)

Manager-QA