

7/86

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		11963	33/50
2	Machined By		Y.T.L M/C Shop	Drg No - LEC 14305
3	Pallet Die No.		11992 (3.0mm)	Cherox
4	Die Category	Drg. No.	MJEW	
5	Out Side Diameter	Drg. No.	70mm, Step of Tapper-19°	Step Length-17mm
6	Inside Diameter	Drg. No.	60.14mm	
7	Width of Pellet Die	Drg. No.	265mm	
8	Grooves as per Drawing	Drg. No.	15X8X7mm / 15X8X7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 16 Both Side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		640mm	
13	Tapping Hole Diameter		M 20 check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.5mm Tapping Depth - 18.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanjeet Singh 17/06/24

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-600 Row-47

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5mm	outside (3-3)	Inner			
3	External Relief Depth		23mm	17mm			
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		17	06	24		

Inspected By (Sign) & Date Ramanjeet Singh 17/06/24

Reviewed by (Engineer-CNC) Satya 17/6/24

Manager-QA