

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.		12/189	45/50
2	Machined By		V.T.L Mic Shop	Dr. No - Lark Std
3	Pallet Die No.		12099 (2.5mm)	1355
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620.1mm	Step Depth - 17.5mm
6	Inside Diameter	Drg. No.	520.14mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5mm / 13 X 8 X 5mm	
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		Mic Shop	
12	Tapping PCD		565mm	
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

Ramanpreet 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 2 Hole close

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter - 60°

1	Counter Sinking Depth & Finish	ok								Row - 43
2	External Relief Dia	2.8mm	outside (3-3)	Inner						
3	External Relief Depth		10mm	5mm						
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		17	06	24					

Inspected By (Sign) & Date

Ramanpreet Singh 17/06/24

Satish 17/06/24

Reviewed by (Engineer-CNC)

Manager-QA