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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.		12199	38/40
2	Machined By		V.T.L M/C Shop	Drg No - LSP 881
3	Pallet Die No.		12745 (3.0 mm)	CRevoo
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500 mm Step OP - 490.7mm	Step Length - 16.5mm
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	173 mm	
8	Grooves as per Drawing	Drg. No.	12 X 10 X 5mm / 12 X 10 X 5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 8 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		455mm	
13	Tapping Hole Diameter		3/4" CHECK by 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.6 mm Tapping Depth - 18.6 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ramanpreet Singh 21/06/24	
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 (A) 1 Hole Close	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker — Counter - 60° Roll - 27

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	3.5 mm	Outside (2-3)	Inner				
3	External Relief Depth		8mm	2mm				
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		21	06	24			
	Inspected By (Sign) & Date		Ramanpreet Singh. 21/06/24					

Satya 21/6/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner