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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.		12236	35/60/90
2	Machined By		V.T.L M/C SHOP	Drg No - LSP 659
3	Pallet Die No.		10372 (6.0mm)	(REV03)
4	Die Category	Drg. No.	MJEW	
5	Out Side Diameter	Drg. No.	752 mm	Step od - 777mm/716 Step length - 42mm
6	Inside Diameter	Drg. No.	572.12mm	675mm 24.5mm
7	Width of Pellet Die	Drg. No.	270mm	Under cut - 12.5mm
8	Grooves as per Drawing	Drg. No.	106X8X12mm / 88X8X12mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 6]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C SHOP	
12	Tapping PCD		660mm	
13	Tapping Hole Diameter		3/4" check by 3/4" Belt	
14	Tapping On Second Side	Half pitch of 1st side	1 Side Tapping & 2nd side 1 Slot	
15	Tapping Hole Depth		Drill Depth - 35.5mm Tapping Depth - 33.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 04/07/24

1 Slot 39mm

1	As per programme no.		—	Width 26mm
2	Gun Drilling Work Completed On		—	Deep
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No 1 Hole close	

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

Counter - 60°

1	Counter Sinking Depth & Finish	OK					Row - 7
2	External Relief Dia	6.5mm 7.0mm	6.5mm	7.0mm			
3	External Relief Depth		55mm	30mm	ALL ROWS		
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		04	07	24		

Inspected By (Sign) & Date

Ramanpreet Singh 04/07/24

Sakya
4/7/24

Reviewed by (Engineer-CNC)

Manager-QA