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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12239	30/66
2	Machined By		V.T.L M/C Shop	Drg No - LSD 609
3	Pallet Die No.		12483 (6.0mm)	(Revol)
4	Die Category	Drg. No.	M. Jumbo groove - 4x3mm	
5	Out Side Diameter	Drg. No.	680.7mm	Step length - 31mm
6	Inside Diameter	Drg. No.	548.12mm	Taper - 8°
7	Width of Pellet Die	Drg. No.	195mm	Underwt - 2.5mm
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8mm / 37 X 7 X 7.8mm	4 X 8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 4
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		619mm	Face Side Step
13	Tapping Hole Diameter		M16 Check by M16 Bolt	2mm Deep Both
14	Tapping On Second Side	Half pitch of 1st side	ok	Side
15	Tapping Hole Depth		Drill Depth - 33.8mm Tapping Depth - 31.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 28/06/24

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 - 30°

1	Counter Sinking Depth & Finish	ok							Row - 12
2	External Relief Dia	7.0 mm	All Rolls						
3	External Relief Depth		36 mm						
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		28	06	24				

Inspected By (Sign) & Date

Ramanjeet Singh 28/06/24

Satyam 28/6/24

Reviewed by (Engineer-CNC)

Manager-QA