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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.		12219	33/40
2	Machined By		V.T.L M/C Shop	Dwg No- LEC-15062
3	Pallet Die No.		11840 (3.0mm)	(Rev 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm	Step length- 18mm
6	Inside Diameter	Drg. No.	Step od- 498.8mm 420.12mm	Tapper- 12°
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12.3 x 8 x 3mm / 12 x 8 x 3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8]
11	Tapping Operator		M/C Shop	[Both Side]
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		M20 check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth- 18.4mm Tapping Depth- 16.5mm	
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 - 60° Row - 24

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5mm	outside (2-2)	Inner			
3	External Relief Depth		13mm	7mm			
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

Reviewed by (Engineer-CNC) [Signature] 28/06/24

Manager-QA