7760

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.		12208	50/50
2	Machined By		V.T.L M/c Shop	Drg No-LEC-13760
3	Pallet Die No.		12322 (8.0mm)	(Rev00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 HH, Step OD = 491 HH	Step Length - 17.5mm
6	Inside Diameter	Drg. No.	420.12 HH	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12X8X3mm / 12X8X3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 9 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454 mm	
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 - 18.3 MM Tapping Depth - 16.5 MM	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ramanpreet Singh 03/07/24	
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°

1	Counter Sinking Depth & Finish	OK						Row-12
2	External Relief Dia	8.5 mm	Outside (7-2)	Inner				
3	External Relief Depth		4mm	0				
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		03	07	24			
	Inspected By (Sign) & Date		Ramanpreet Singh 03/07/24					

Satya 3/7/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner