7817

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.		12264	30/40
2	Machined By		V.T.L M/c Shop	Drg No-LSD/031
3	Pallet Die No.		12760 (3.0mm)	(Revised)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	388 mm Step-381.7mm	Step Length-11.5mm
6	Inside Diameter	Drg. No.	310.12mm	
7	Width of Pellet Die	Drg. No.	144mm	
8	Grooves as per Drawing	Drg. No.	12X8X3mm / 12X8X3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes & Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		350 mm	
13	Tapping Hole Diameter		5/8" Check by 5/8" Tap	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth-18.3mm Tapping Depth-16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ramanjeet Singh 11/07/24	
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-RR
2	External Relief Dia	3.5mm	outside CR-RR	Inner				
3	External Relief Depth		13mm	10mm				
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		11	07	24			
	Inspected By (Sign) & Date		Ramanjeet Singh 11/07/24					

Satyam 11/7/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner