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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.		12353	42/66
2	Machined By		V.T.L M/C Shop	Proj No - LSP 788
3	Pallet Die No.		12776 (60mm)	(Revol)
4	Die Category	Drg. No.	M. Jumps	
5	Out Side Diameter	Drg. No.	678mm	Step length - 38mm / 335mm
6	Inside Diameter	Drg. No.	548.12mm	Under cut - 235mm
7	Width of Pellet Die	Drg. No.	195mm	Taper - 8°
8	Grooves as per Drawing	Drg. No.	31 X 8 X 8mm / 31 X 8 X 8mm	4 X 8mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No of Holes 2]
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		M 16 check by M 16 Bolt	1mm Deep
14	Tapping On Second Side	Half pitch of 1st side	OK	Both side
15	Tapping Hole Depth		Drill Depth - 38.4mm Tapping Depth - 36.5mm	
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 - 30°

1	Counter Sinking Depth & Finish	OK								Row - 12
2	External Relief Dia	7.0mm	0.11mm							
3	External Relief Depth		24mm							
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

Satish
11/7/24

Reviewed by (Engineer-CNC)

Manager-QA