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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.			
2	Machined By		R391	60/70
3	Pallet Die No.		V.T.L M/C SHOP	Drg No- LSP 681
4	Die Category	Drg. No.	8507 (8.0mm)	(Revol)
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	840mm	Stel length-26.5mm
7	Width of Pellet Die	Drg. No.	700mm	
8	Grooves as per Drawing	Drg. No.	370mm	
9	Fitting Sizes on CNC Plate	Drg. No.	25 X 10 X 9mm / 25 X 10 X 9mm	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 12 Both Side
11	Tapping Operator		M/C SHOP	
12	Tapping PCD		750mm	
13	Tapping Hole Diameter		M 20 Check by M 20 Bolt	Face Side Stel 0.3mm
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth-35mm Tapping Depth-33.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 29/07/24

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-30
2	External Relief Dia	9.0mm	Outside (3-3)	Inner				
3	External Relief Depth		18mm	10mm				
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		29	07	24			

Inspected By (Sign) & Date Ramanpreet Singh 29/07/24

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29/7/24

Reviewed by (Engineer-CNC)

Manager-QA