

7914 243



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.		12299	35/13/78
2	Machined By		V.T.L M/C Shop	Drg No - LSP 396
3	Pallet Die No.		11740 (60mm)	CRev 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	636 mm	Step od - 530.5mm / Step Length - 26mm / 16.5
6	Inside Diameter	Drg. No.	480mm / 489 / 500mm	542mm
7	Width of Pellet Die	Drg. No.	182mm	
8	Grooves as per Drawing	Drg. No.	37 X 8 X 9.5mm / 27 X 8 X 9.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 4]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		540mm	
13	Tapping Hole Diameter		M 16 Check by M 16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	1 Side Tapping & 2nd side 1 Slot	
15	Tapping Hole Depth		Drill Depth - 28.4mm Tapping Depth - 26.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanpreet Singh 30/07/24	1 Slot 28mm
1	As per programme no.		—	Width 17mm Drill
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 - 10
2	External Relief Dia	7.0mm, 7.5mm	7.0mm	7.5mm
3	External Relief Depth		43mm	15mm All Rows
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		30 07 24	
Inspected By (Sign) & Date			Ramanpreet Singh 30/07/24	

Sats 30/07/24

Reviewed by (Engineer-CNC)

Manager-QA