

7896

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.		12440	50/50
2	Machined By		V.T.L M/C Shop	Drg No - LSP 239
3	Pallet Die No.		12134 (6.0mm)	CREV00
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620 H4 Step 00, 6228	Step length - 17.5mm
6	Inside Diameter	Drg. No.	520.14 H4	Tapper - 12°
7	Width of Pellet Die	Drg. No.	222mm ✓	Under cut - 1.4mm
8	Grooves as per Drawing	Drg. No.	14 X 8 X 5 mm / 14 X 8 X 5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 12 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565mm ✓	
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 - 22.3mm Tapping Depth - 20.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanpreet Singh 26/07/24	
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 - 23
2	External Relief Dia	6.5mm	outside (3-3) Inner	
3	External Relief Depth		4mm, 0	
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh	
5	Material Sent For Hardening By (Name)		Leak Furnace	
6	Material Sent For Hardening On Date		26 07 24	
Inspected By (Sign) & Date			Ramanpreet Singh 26/07/24	

Reviewed by (Engineer-CNC) *Satsou* 26/07/24

Manager-QA