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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|-------------------------|-----------------------------------|
| 1 | Work Order No. | | 1P/PS | 46/50 |
| 2 | Machined By | | V.T.L M/C Shop | Drg No-LFC 9980 |
| 3 | Pallet Die No. | | 1P591(4.0mm) | CNC/00 |
| 4 | Die Category | Drg. No. | SSEW | |
| 5 | Out Side Diameter | Drg. No. | 619.8mm | Step of Tapper 1° |
| 6 | Inside Diameter | Drg. No. | 520.12mm | step length-18.5mm |
| 7 | Width of Pellet Die | Drg. No. | 222mm | |
| 8 | Grooves as per Drawing | Drg. No. | 13x8x5mm / 13x8x5mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | Tapping No. of Holes 1° Both Side |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | M/C Shop | |
| 12 | Tapping PCD | | 565mm | |
| 13 | Tapping Hole Diameter | | M 20 check by M 20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth-20.4mm | Tapping Depth-18.5mm |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ramanjeet Singh 06/8/24

| | | | |
|---|--------------------------------|--------|----|
| 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-31 |
| 2 | External Relief Dia | 4.5mm | Outside (3-3) | Inner | | | | | |
| 3 | External Relief Depth | | 12mm | 4mm | | | | | |
| 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 | | 06 | 08 | 24 | | | | |

Inspected By (Sign) & Date

Ramanjeet Singh 06/8/24

Signature
6/8/24

Reviewed by (Engineer-CNC)

Manager-QA