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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.		12209 to 12556	48/66
2	Machined By		V.T.L M/c Shop	Drg No- LSP 609
3	Pallet Die No.		12793 (8.0mm)	(REV 01)
4	Die Category	Drg. No.	M Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm, Step 00-893mm	Step length-3/22/33mm
6	Inside Diameter	Drg. No.	548.12 mm	Tapper 2 8°
7	Width of Pellet Die	Drg. No.	195mm	Under cut 2.5mm
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8mm / 32 X 7 X 8mm	4+8
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	Both Side
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M16 check by M16 Bolt	Face Side
14	Tapping On Second Side	Half pitch of 1st side	ok	Step 2mm Qab
15	Tapping Hole Depth		Drill Depth - 34mm Tapping Depth - 31.5mm	Both Side
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanjeet Singh 08/08/24

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-10
2	External Relief Dia	9.0mm	All Rows					
3	External Relief Depth		18mm					
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		08	08	24			

Inspected By (Sign) & Date Ramanjeet Singh 08/08/24

Reviewed by (Engineer-CNC)

Manager-QA