

8004

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.		12598	27/50
2	Machined By		V.T.L M/c Shop	Reg No - LSD 459
3	Pallet Die No.		12816 (3.0mm)	(Rev00)
4	Die Category	Drg. No.	SSEW	✓
5	Out Side Diameter	Drg. No.	620.2mm Step od - 622.7mm	Step length - 20mm
6	Inside Diameter	Drg. No.	520.12mm	Undercut - 14mm
7	Width of Pellet Die	Drg. No.	222mm	Taper - 12°
8	Grooves as per Drawing	Drg. No.	12 X 8 X 7mm / 12 X 8 X 7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 12
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm	Both Side
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 - 20.5mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	✓
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanjeet Singh 20/08/24

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

1	Counter Sinking Depth & Finish	OK						Counter-60°
2	External Relief Dia	3.5mm	Outside (3-3)	Inner				Row-39
3	External Relief Depth		26mm	23mm				
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		20	08	24			

Inspected By (Sign) & Date Ramanjeet Singh 20/08/24

Reviewed by (Engineer-CNC)

Manager-QA