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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.		12670	50/50	
2	Machined By		V.T.L M/c Shop	Dwg No-LSD 153	
3	Pallet Die No.		13030 (8.0mm)	(REV 00)	
4	Die Category	Drg. No.	Senior		
5	Out Side Diameter	Drg. No.	520mm Step 02, 491mm	Step Length-16.5mm	
6	Inside Diameter	Drg. No.	420.12mm		
7	Width of Pellet Die	Drg. No.	160mm		
8	Grooves as per Drawing	Drg. No.	12X9X3mm / 12X9X3mm		
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 8 Both Side]	
10	Drilling Area Surface Smoothness		OK		
11	Tapping Operator		M/c Shop		
12	Tapping PCD		454mm		
13	Tapping Hole Diameter		3/4 check by 3/4 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			Ramanpreet Singh 26/08/24		
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-60°					
1	Counter Sinking Depth & Finish	OK		Row-12	
2	External Relief Dia	8.5mm	outside inner		
3	External Relief Depth		5mm 0		
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		26	08	24
Inspected By (Sign) & Date			Ramanpreet Singh 26/08/24		

Reviewed by (Engineer-CNC)

Manager-QA