8/25

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.		12730	40/50
2	Machined By		V.T.L M/c Shop	Drg No- LSD450 (Rev 00)
3	Pallet Die No.		12748 (4.0mm)	
4	Die Category	Drg. No.	Jumbo EW	
5	Out Side Diameter	Drg. No.	730mm Stepd-743.5mm	Step Length- 23mm
6	Inside Diameter	Drg. No.	630.12mm	Tapper - 10°
7	Width of Pellet Die	Drg. No.	290mm	Under Cut- 6.75mm
8	Grooves as per Drawing	Drg. No.	15X8X5mm / 15X8X5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 16 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		685mm	
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- 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 02/09/24	
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° Row-8
2	External Relief Dia	4.5mm	outside (3-3)	Inner					
3	External Relief Depth		14mm	10mm					
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		02	09	24				
	Inspected By (Sign) & Date		Ramanpreet Singh 02/09/24						

Satya 2/9/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner