8184

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.		12769	35/55
2	Machined By		V.T.L M/c Shop	Drg No - LSP 755
3	Pallet Die No.		11540 (4.5mm)	(Rev 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	737 mm Step OD = 754.3	Step length - 29mm
6	Inside Diameter	Drg. No.	(A) 630.12 mm (Box = 627 mm)	Tapper = 10°
7	Width of Pellet Die	Drg. No.	256 mm	Undercut - 8.95
8	Grooves as per Drawing	Drg. No.	19.5 X 10 X 8mm / 19.5 X 10 X 8mm	(A)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 12 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		689 mm	
13	Tapping Hole Diameter		M24 Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 28.4mm Tapping Depth - 26.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ramanpreet Singh 11/09/24	
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 - 31
2	External Relief Dia	5.0mm	outside (3-3)	Inner				
3	External Relief Depth		25mm	20mm				
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		11	09	24			
	Inspected By (Sign) & Date		Ramanpreet Singh. 11/09/24					

11/9/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner