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.		12796	55/66
2	Machined By		V.T.L M/c Shop	Drg No - LSD 607
3	Pallet Die No.		13279 (8.0mm)	(Rev 01)
4	Die Category	Drg. No.	M Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm / Step OD - 693	Step length - 31mm
6	Inside Diameter	Drg. No.	548.10 mm	Tapper = 8°
7	Width of Pellet Die	Drg. No.	195mm	Undercut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8 mm / 32 X 7 X 8 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 4 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	[Face Side Step 2 mm Deep Both Side
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 33.4mm Tapping Depth - 31.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ramanpreet Singh 17/09/24	
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 — Counter-36

1	Counter Sinking Depth & Finish	ok						Row-10
2	External Relief Dia	9.0mm	All Rows					
3	External Relief Depth		11mm					
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		17	09	24			
	Inspected By (Sign) & Date		Ramanpreet Singh 17/09/24					

Satya 17/9/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner