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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.		12916 ✓	35/50
2	Machined By		V.T.L M/c Shop	Dwg No - LSD 419
3	Pallet Die No.		12553 (2.8mm)	(REV 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700mm Step OD - 692mm	Step length - 19.5mm
6	Inside Diameter	Drg. No.	600.12mm	
7	Width of Pellet Die	Drg. No.	222mm ✓	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7mm / 12.5 x 8 x 7mm	
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		645mm ✓	
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 - 22.4mm Tapping Depth - 20.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ramanpreet Singh 26/09/24*

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 - 40
2	External Relief Dia	3.3mm ✓	outside (3.3)	Inner				
3	External Relief Depth		20mm	15mm ✓				
4	Inspection Done Before Hardening By (Name)		<i>Ramanpreet Singh</i>					
5	Material Sent For Hardening By (Name)		<i>Lark Furnace</i>					
6	Material Sent For Hardening On Date		26	09	24			

Inspected By (Sign) & Date *Ramanpreet Singh 26/09/24*

Satish
26/09/24
Reviewed by (Engineer-CNC)

Manager-QA