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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.		11887	45/60
2	Machined By		V.T.L M/C SHOP	Drg No - LSD - 584
3	Pallet Die No.		12405 (8.0mm)	CREV01
4	Die Category	Dr. No.	Jumbo	
5	Out Side Diameter	Dr. No.	780mm, step of - 798mm	Tapper - 4°
6	Inside Diameter	Dr. No.	660.12mm	Step length - 25.5mm
7	Width of Pellet Die	Dr. No.	324mm	Under cut 9.0mm
8	Grooves as per Drawing	Dr. No.	21.5 X 8 X 10mm / 21.5 X 8 X 10mm	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	Tapping No. of Holes 12 Both side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C SHOP	
12	Tapping PCD		725mm	
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 - 31mm Tapping Depth - 28.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ramanpreet Singh 24/5/24	2 Slot 32.1mm width 8mm Deep Both side
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° Row - 27
1	Counter Sinking Depth & Finish	ok		
2	External Relief Dia	8.5mm	outside (13-3) Inner	
3	External Relief Depth		23mm 15mm	
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		24 5 24	
Inspected By (Sign) & Date			Ramanpreet Singh 24/5/24	

Satya 24/5/24
Reviewed by (Engineer-CNC)

Manager-QA