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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.			
2	Machined By		12075	31/50
3	Pallet Die No.		V.T.L M/C Shop	Drg No - LSD-276
4	Die Category	Drg. No.	11663 (2.8mm)	(Rev 01)
5	Out Side Diameter	Drg. No.	SSSTD	
6	Inside Diameter	Drg. No.	620mm Step od - 624mm	Step Length - 20mm
7	Width of Pellet Die	Drg. No.	520.12mm	Under Cut - 2mm
8	Grooves as per Drawing	Drg. No.	186mm	Taper - 12°
9	Fitting Sizes on CNC Plate	Drg. No.	13X8X5mm / 13X8X5mm	
10	Drilling Area Surface Smoothness		ok	[Tapping No of Holes 12 Both Side]
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565mm	
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 - 20.8mm Tapping Depth - 18.7mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanjeet Singh 31/5/24

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 - 60°

1	Counter Sinking Depth & Finish	ok							Row - 31
2	External Relief Dia	3.1mm	outside (3-3)	Inner					
3	External Relief Depth		25mm	19mm					
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		31	5	24				

Inspected By (Sign) & Date Ramanjeet Singh 31/5/24

Satya 31/5/24

Reviewed by (Engineer-CNC)

Manager-QA