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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.		12077	42/50
2	Machined By		V.T.L M/C Shop	Drg No - Lark Std
3	Pallet Die No.		12378 (3.5mm)	6355
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm, Std od - 612mm	Step length - 17.5mm
6	Inside Diameter	Drg. No.	520.12mm / 520.5mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. ok]
10	Drilling Area Surface Smoothness		OK	Holes 12
11	Tapping Operator		M/C Shop	- Both Side]
12	Tapping PCD		585mm	
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 - 18.8mm	
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 - 35
2	External Relief Dia	4.0mm	outside (3-3)	inner				
3	External Relief Depth		15mm	8mm				
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