

7597



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.		11913	40/45
2	Machined By		V.T.L M/C Shop	Drg No-LSL-807
3	Pallet Die No.		12091 (6.0mm)	(REV00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	51.0mm	Step length-17.5mm
6	Inside Diameter	Drg. No.	Step od- 49.2mm	
7	Width of Fellet Die	Drg. No.	42.12mm	
8	Grooves as per Drawing	Drg. No.	158mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm / 12x8x3mm	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8 Both Side]
11	Tapping Operator		M/C Shop	
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		3/4 Check by 3/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth- 19.8mm Tapping Depth- 17.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet 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

1	Counter Sinking Depth & Finish	ok					Counter-60°
2	External Relief Dia	6.5mm	outside	Inner			Row- 15
3	External Relief Depth		11mm	5mm			
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		31	5	24		

Inspected By (Sign) & Date

Ramanpreet Singh 31/5/24

Saty 31/5/24

Reviewed by (Engineer-CNC)

Manager-QA