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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.		12080	40/50
2	Machined By		V.T.L M/C Shop	Drg No - LSD-1064
3	Pallet Die No.		12306 (3.5mm)	(REV 01)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760mm, step OD - 802.3mm	Step Length - 30mm
6	Inside Diameter	Drg. No.	66-12mm	Tapered - 10°
7	Width of Pellet Die	Drg. No.	290mm	Under cut - 21-3mm
8	Grooves as per Drawing	Drg. No.	27x8x7.5mm / 27x8x7.5mm	
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		74mm	
13	Tapping Hole Diameter		M22 Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 30mm Tapping Depth - 27.8mm	
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 -
2	External Relief Dia	4.0mm	outside (3.3)	inner						
3	External Relief Depth		17mm	10mm						
4	Inspection Done Before Hardening By (Name)		<i>Ramanjeet Singh</i>							
5	Material Sent For Hardening By (Name)		<i>Lark Furnace</i>							
6	Material Sent For Hardening On Date		31	5	24					

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

Setsu 31/5/24

Reviewed by (Engineer-CNC)

Manager-QA