Hoda 7635

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.		INV-TO 12192	39/50
2	Machined By		VTL M/C Shop	Drg No LEC 9780
3	Pallet Die No.		12576 (3.0mm)	(Rev 00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620 mm Step OD Taper-12°	Step Length - 18.5mm
6	Inside Diameter	Drg. No.	520.12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13X8X5 mm / 13X8X5 mm	
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		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 - 20.7mm Tapping Depth - 18.7mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ramanpreet Singh 08/6/24	

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° Row - 38

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.3 mm	Outside (3-3)	Inner				
3	External Relief Depth		17mm	11mm				
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		08	6	24			
	Inspected By (Sign) & Date		Ramanpreet Singh 08/6/24					

Satya 10/6/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner