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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.		11994	45/70
2	Machined By		V.T.L M/c Shop	Drg No-LEC-12/02
3	Pallet Die No.		12191 (30mm)	(Rev01)
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1287mm Step of 1283mm	Step length - 22mm
6	Inside Diameter	Drg. No.	1145.12mm	
7	Width of Pellet Die	Drg. No.	388.5mm	
8	Grooves as per Drawing	Drg. No.	26 X 6 X 13mm / 26 X 6 X 13mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 20 Both side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		1210mm	
13	Tapping Hole Diameter		M 24 Check by M 24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 33.5mm Tapping Depth - 31.3mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 14/06/24

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 5 Hole close (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 60 Row - 69

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.5mm	out side 4.5	Inner				
3	External Relief Depth		31mm	25mm				
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		14	06	24			

Inspected By (Sign) & Date Ramanpreet Singh 14/06/24

Satya 14/06/24

Reviewed by (Engineer-CNC)

Manager-QA