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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.		12123	34/40
2	Machined By		V.T.L M/C Shop	Drg No - LSP 942
3	Pallet Die No.		12587 (2.8mm)	(REV 00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	600mm	Step Depth - 21.5mm
6	Inside Diameter	Drg. No.	520.12mm	Tapped - 12°
7	Width of Pellet Die	Drg. No.	222mm	Under cut - 10.75mm
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm	
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 - 20.5mm Tapping Depth - 18.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 11/06/24

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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 60° Row - 39

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia		3.1mm				
3	External Relief Depth		8mm	All Rnds			
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		11	06	24		

Inspected By (Sign) & Date Ramanpreet Singh 11/06/24

Satya
11/06/24

Reviewed by (Engineer-CNC)

Manager-QA