7647

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.		12035 ✓	23/35/85 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 84
3	Pallet Die No.		11008 (6.0mm) ✓	(Rev 01) ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	830 mm ✓ Step OD. 803 mm ✓	Step Length - 43 mm ✓ Tapper - 12° ✓
6	Inside Diameter	Drg. No.	700.12 mm ✓	
7	Width of Pellet Die	Drg. No.	340 mm ✓	
8	Grooves as per Drawing	Drg. No.	37 x 8 x 12 mm | 37 x 8 x 12 ✓	
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		742 mm ✓	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - ~~25~~ 25 mm Tapping Depth - 23.5mm ✓	
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

1	Counter Sinking Depth & Finish	ok						Counter - 60° ✓ Rad - 3?
2	External Relief Dia		7.0 mm		6.5 mm			
3	External Relief Depth		3.0 mm ✓		4? mm			
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh					Discussed with Sales.
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 11/6/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner