

7683

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.			
2	Machined By		R182	30/50
3	Pallet Die No.		V.T.2 M/C Shop	Drg No. - LEC 9280
4	Die Category	Drg. No.	12592 (3.0mm)	CRV00
5	Out Side Diameter	Drg. No.	SSEW	
6	Inside Diameter	Drg. No.	620mm, Step of Tapper-12°	Step Length - 13.5mm
7	Width of Pellet Die	Drg. No.	520-14mm	
8	Grooves as per Drawing	Drg. No.	222mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13X8X5mm / 13X8X5mm	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 12 Both Side]
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M 20 Check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 13.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 17/06/24

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°

1	Counter Sinking Depth & Finish	OK							Row-38
2	External Relief Dia	3.5mm	outside (3-3)	Inner					
3	External Relief Depth		23mm	20mm					
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		17	06	24				

Inspected By (Sign) & Date

Ramanjeet Singh 17/06/24

Satsa
17/6/24
Reviewed by (Engineer-CNC)

Manager-QA