7694

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.		11925	49/65
2	Machined By		V.T.L M/C Shop	Drg No - LSD 693
3	Pallet Die No.		11764 (3.8mm)	(Rev 00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	830 mm Step OD - 823mm	Step Length - 33mm
6	Inside Diameter	Drg. No.	700.12mm	Taper - 4°
7	Width of Pellet Die	Drg. No.	324 mm	
8	Grooves as per Drawing	Drg. No.	30 X 8 X 8.5mm / 30 X 8 X 8.5mm	
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		760 mm	
13	Tapping Hole Diameter		M22 Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 36.6 mm Tapping Depth - 34.5 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ramanpreet Singh 19/06/24	
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 - 46
2	External Relief Dia	4.5 mm	Outside (3-3)	Inner				
3	External Relief Depth		23 mm	16 mm				
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		19	06	24			
	Inspected By (Sign) & Date		Ramanpreet Singh 19/06/24					

Satish 19/6/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner