

7768



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.		12184	35/40/66
2	Machined By		V.T.L M/c Shop	Drg No-LSD 609
3	Pallet Die No.		12801 (6.0mm)	(Revol)
4	Die Category	Drg. No.	M. Jumbo 3700VC 4X3mm	
5	Out Side Diameter	Drg. No.	680.7mm	Step length-31mm
6	Inside Diameter	Drg. No.	548.12mm	Taper-8°
7	Width of Pellet Die	Drg. No.	195mm	Undercut-2.5mm
8	Grooves as per Drawing	Drg. No.	32X7X8mm / 32X7X8mm	4X8mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 4 Both side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	Face side step
13	Tapping Hole Diameter		M16 check by M16 Bolt	2mm Deel Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth-34mm	Tapping Depth-32mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanjeet Singh 04/07/24	
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 <u>Counter-30°</u>				
1	Counter Sinking Depth & Finish	OK		Row-12
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm
3	External Relief Depth		31mm	26mm All Rows
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		04	07 24
Inspected By (Sign) & Date			Ramanjeet Singh 04/07/24	

Sasouli
4/7/24

Reviewed by (Engineer-CNC)

Manager-QA