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.		12940	28/43/80
2	Machined By		V.T.L. M/c Shop	Drg No. L.S.D = 700
3	Pallet Die No.		12072 (6.0) MM	Rev = 03
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	730 MM, Step OD = 732 MM / 632 MM	
6	Inside Diameter	Drg. No.	572.12 MM	Step length = 30 MM 18.5 MM
7	Width of Pellet Die	Drg. No.	219 MM	Under cut = 1 MM
8	Grooves as per Drawing	Drg. No.	75×8×8 MM / 58×8×8 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/c Shop	[Tapping No of Holes = 6]
12	Tapping PCD		650 MM	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and IInd Side One Slot	
15	Tapping Hole Depth		Drill Depth = 40.4 MM Tapping Depth = 38.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 23/9/24	[1 Slot 32.1 MM width 19 MM Deep]
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	Slot Rework After Hard.

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	Ok						Counter = 60° Row = 8
2	External Relief Dia	6.5 MM / 7.0 MM	6.5 MM	All Rows	7.0 MM	All Rows		
3	External Relief Depth			52 MM		37 MM		
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		23	9	24			
	Inspected By (Sign) & Date		Ravi 23/9/24					

Satya 23/9/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner