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.		12967	25/30/65
2	Machined By		V.T.L M/C Shop	Dg No. LSD-[illegible]
3	Pallet Die No.		13339(6.0) MM	Rev: 08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 MM Step OD = 693 MM	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 MM / Bore = 548.1 MM	Step length = 31 MM
7	Width of Pellet Die	Drg. No.	195 MM	Undercut = 2.5 MM
8	Grooves as per Drawing	Drg. No.	32×7×9.1 MM / 32×7×9.1 MM	(4×8) MM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 MM Deep Both Side
11	Tapping Operator		M/C Shop	Tapping No
12	Tapping PCD		619 MM	of Holes = 2
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 35 MM Tapping Depth = 32.5 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 8/10/24	
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 = 30°

1	Counter Sinking Depth & Finish	Ok						Row = 12
2	External Relief Dia	6.5 MM / 7.0 MM	6.5 MM All Rows		7.0 MM All Rows			
3	External Relief Depth		41 MM			36 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		8	10	24			
	Inspected By (Sign) & Date		Ravi 8/10/24					

8/10/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner