

8483



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.		13135	40/55
2	Machined By		V.T.L. H/c Shop	Dry Hole 1.8.0. 1173
3	Pallet Die No.		13414 (B.O) H/c	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710 H/c	Step 00. 693 H/c
6	Inside Diameter	Drg. No.	600.12 H/c	Tabber = 12"
7	Width of Pellet Die	Drg. No.	222 H/c	Step length 30 H/c
8	Grooves as per Drawing	Drg. No.	12.2 x 8 x 5 H/c 12 x 8 x 5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c	[Tapping No. of Hole 212 Both Side]
12	Tapping PCD		640 H/c	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 6/11/24

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

1	Counter Sinking Depth & Finish	OK						Counter = 60
2	External Relief Dia	6.5 H/c	Outside (23-3)		Inner			Rev = 23
3	External Relief Depth		21 H/c		15 H/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		6	11	24			

Inspected By (Sign) & Date Ravi 6/11/24

Satyam
6/11/24
Reviewed by (Engineer-CNC)

Manager-QA