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.		13354	33/53/70
2	Machined By		V.T.L. N/C Shop	Dwg No. 12.9.377
3	Pallet Die No.		12931 (6.0) MM	Rev. 03
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	688 MM, Step OD = 697.8 MM	Tapper 5°
6	Inside Diameter	Drg. No.	548.1 MM	Step length 38.5
7	Width of Pellet Die	Drg. No.	215 MM	Under cut 1.8 MM
8	Grooves as per Drawing	Drg. No.	29.5x10x8 MM / 29.5x10x8 MM	(6x8) MM
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	Face Side Step 1MM Deep Both Side
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		N/C. Shop	Tapping No of Holes = 2 Both Side
12	Tapping PCD		618 MM	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 32.4 MM	Tapping Depth. 30.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 26/11/24	
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 30° Rev 2 14
2	External Relief Dia	6.5 MM / 7.0 MM	6.5 MM All Rows	37 MM					
3	External Relief Depth		7.0 MM All Rows	17 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		26	11	24				
	Inspected By (Sign) & Date		Ravi 26/11/24						

Sotf 29/11/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner