

8677



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.		13470	38/45
2	Machined By		V.T.L. N/C Shop	Drg. No. 1.2.0.429
3	Pallet Die No.		13358(5.0) H/H	Rev. 1.00
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	51.0 H/H, Step OD = 49.1 H/H	Step length 17.4
6	Inside Diameter	Drg. No.	42.0 ± 0.12 H/H	
7	Width of Pellet Die	Drg. No.	18.2 H/H	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/H 12 x 8 x 3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping N. of holes, P. Both side
12	Tapping PCD		45.4 H/H	
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 = 18.3 H/H Tapping Depth = 16.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/7/24

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 = 60

1	Counter Sinking Depth & Finish	OK							Rev = 21
2	External Relief Dia	5.5 H/H	Outside (2-2)		Inner				
3	External Relief Depth		18 H/H		Free				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		3	12	24				

Inspected By (Sign) & Date

Ravi 31/7/24

Reviewed by (Engineer-CNC)
31/7/24

Manager-QA