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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.		12690	37/37
2	Machined By		V.T.L M/c Shop	Dy No. 63.0.109 Rev. 00
3	Pallet Die No.		13153(1.6) MM	
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	604 MM / Step OD 582 MM / 598 MM	
6	Inside Diameter	Drg. No.	530.12 MM	Step length, 7 MM
7	Width of Pellet Die	Drg. No.	8 7.8 MM	Under cut 39 MM 17.5 MM
8	Grooves as per Drawing	Drg. No.	8 7×8×8 MM / 43×8×8 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 8
12	Tapping PCD		594 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 25.3 MM Tapping Depth 23.5	
16	Perpendicularity of Tapped Hole		4.3	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 9/12/24	1 Slot 29.1 MM width 18 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 - 9 Hole Closed (A)	

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

Counter 60° Rev. 116

1	Counter Sinking Depth & Finish	Ok						
2	External Relief Dia	—	—	No	Relief			
3	External Relief Depth		—	—	—			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lower Furnace					
6	Material Sent For Hardening On Date		9	12	24			
	Inspected By (Sign) & Date		Ravi 9/12/24					

Reviewed by (Engineer-CNC) 10/12/24

Manager-QA

Scanned with CamScanner