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.		13481	55/66
2	Machined By		V.T.L M/c Shop	Drg No. LBD-320
3	Pallet Die No.		13795 (10.0) mm	Rev. 08
4	Die Category	Drg. No.	M. Tumbo	
5	Out Side Diameter	Drg. No.	680.1 mm, Step OD - 693.1 mm	Tapper 8°
6	Inside Diameter	Drg. No.	548.12 mm (Box 548.1)	Step length 31 mm 31.3 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut 23 mm
8	Grooves as per Drawing	Drg. No.	32x7x9.1 mm / 32x7x9.1 mm (4x8)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Face Side Step 2 mm Deep Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	[Tapping No. of Holes 2 Both Side]
12	Tapping PCD		619 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 33.3 mm	Tapping Depth 31.6 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 12/12/24	
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° Row 8
2	External Relief Dia	11.0 mm	[Ist Pad 11 mm]		[IInd Pad Nill]			
3	External Relief Depth							
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		12	12	24			
	Inspected By (Sign) & Date		Ravi 12/12/24					

Reviewed by (Engineer-CNC) 13/12/24.

Manager-QA

Manager-QA

Scanned with CamScanner