8683

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.		13413	45/60
2	Machined By		V.T.L. H/c Shop	Dy No: 1,3,9,11 Rev: 00
3	Pallet Die No.		13817 (3.0) HH	
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 HH Step OD: 792 HH	Step length 26.5 Under cut: 6 HH
6	Inside Diameter	Drg. No.	660.12 HH	
7	Width of Pellet Die	Drg. No.	384 HH	
8	Grooves as per Drawing	Drg. No.	21.5x8x8 HH | 21.5x8x8 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		H/c Shop	Tapping No of Holes: 12 Both Side
12	Tapping PCD		785 HH	
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: 31 HH Tapping Depth 29.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 3/12/24	
1	As per programme no.		—	2 Slot 39.1 HH width 8 HH Depth Both Side
2	Gun Drilling Work Completed On		—	
3	Hole Finish In Gun Drilling	Marked	Ok	
4	Defective Holes (If Any)		No: 3 Hole Closed (A)	

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

Counter: 60 Row: 57

1	Counter Sinking Depth & Finish	Ok						
2	External Relief Dia	3.8 HH	Outside (3-3)		Inner			
3	External Relief Depth		21 HH		15 HH			
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 3/12/24					

Ravi 3/12/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner