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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.		13783	42/72/9
2	Machined By		V. T.L. H/C Shop	By No. 12.0-738
3	Pallet Die No.		11766(8.0)H	Rev=00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	779.8 H [⊕] Step 00	703H Tapper 4°
6	Inside Diameter	Drg. No.	800.12 H	Step length 38H
7	Width of Pellet Die	Drg. No.	281 H	
8	Grooves as per Drawing	Drg. No.	57x6x10 H / 57x6x10 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping of holes 12 Boiler side
12	Tapping PCD		855 H	
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 24.8 H	Tapping Depth 26
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 14/1/25	
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 Bo. Row 9
2	External Relief Dia	8.5 H / 9.0 H	8.5 H All Rows 242 H	
3	External Relief Depth		9.0 H All Rows 18 H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		14 / 1 / 25	
Inspected By (Sign) & Date			Ravi 14/1/25	

Reviewed by (Engineer-CNC) *Satyam* 14/1/25

Manager-QA