9087

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.		13983	34/50
2	Machined By		V.T.L M/C Shop	Drg No. LEC 12501
3	Pallet Die No.		13555 (3.0) MM	Rev 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 MM Step OD = 693 MM	Tapper = 12°
6	Inside Diameter	Drg. No.	600.12 MM / 600.14 MM (A)	Step length = 20 MM
7	Width of Pellet Die	Drg. No.	222 MM	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 MM / 12 x 8 x 7 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 = 12 Both Side
12	Tapping PCD		640 MM	
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 = 20.2 MM Tapping Depth = 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 27/1/25	
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

Counter = 60°

1	Counter Sinking Depth & Finish	Ok						Rev = 39
2	External Relief Dia	3.5 MM	Outside (3-3)		Inner			
3	External Relief Depth		22 MM		16 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		27	1	25			
	Inspected By (Sign) & Date		Ravi 27/1/25					

Satya 27/1/25.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner