9220

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.		14084	33/66
2	Machined By		V.T.L. M/C Shop	Drg No. 13.0.320
3	Pallet Die No.		14021 (6.0) MM	Rev. 08
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 MM, Step OD: 692.7 MM (Grooves)	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 MM (Bor 548.1 MM)	Step length: 31 MM
7	Width of Pellet Die	Drg. No.	195 MM	Under cut: 2.5 MM
8	Grooves as per Drawing	Drg. No.	32x7x9.1 MM / 32x7x9.1 MM	(4x8) MM
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		ok	[Race side Step 2 MM Deep Both Side]
11	Tapping Operator		M/C Shop	
12	Tapping PCD		619 MM	
13	Tapping Hole Diameter		M16: Check by M16 Bolt	[Tapping No of Holes. 2 Both Side]
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 33.2 MM	Tapping Depth: 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 18/2/25	
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 30° Rows 12
2	External Relief Dia	7.5 MM	All	Rows				
3	External Relief Depth			33 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		18	2	25			
	Inspected By (Sign) & Date		Ravi 18/2/25					

Satya 18/2/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner