

9420

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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14447	36/64/78
2	Machined By		V.T.L. n/c Shop	Dy. n/c 28.0.890
3	Pallet Die No.		14216 (G.5) n/c	See. 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	636 n/c / 632 n/c Step 00 = 630.5 n/c	543 n/c
6	Inside Diameter	Drg. No.	480.12 n/c / 489.12 n/c / 500.12 n/c	Step length 26 n/c
7	Width of Pellet Die	Drg. No.	182 n/c	16.5 n/c
8	Grooves as per Drawing	Drg. No.	37 x 12 x 8 x 9.5 n/c / 27 x 12 x 8 x 9.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holes 4
12	Tapping PCD		540 n/c	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and End Side One Slot	
15	Tapping Hole Depth		Drill Depth 28.2 n/c Tapping Depth 28.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			See: 20/3/25	P 1212
1	As per programme no.			28.1 n/c 10.2 n/c
2	Gun Drilling Work Completed On			17 n/c Deep
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 28.5
2	External Relief Dia	7.0 n/c / 7.5 n/c	7.0 n/c All Rows 2 42 n/c	
3	External Relief Depth		7.5 n/c All Rows 1 14 n/c	
4	Inspection Done Before Hardening By (Name)		See:	
5	Material Sent For Hardening By (Name)		Lark Parnace	
6	Material Sent For Hardening On Date		20 3 25	
Inspected By (Sign) & Date			See: 20/3/25	

Reviewed by (Engineer-CNC)

Manager-QA