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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.		16549	35/63/78
2	Machined By		V.T.L n/c Shop	Dry No. I.S.O. 396
3	Pallet Die No.		10900 (6.0)mm	Revised
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	636mm / 638mm Step 00: 630.5mm / 543mm	
6	Inside Diameter	Drg. No.	480.1mm / 489.1mm / 500.1mm	Step length 26mm
7	Width of Pellet Die	Drg. No.	182mm	16.5mm
8	Grooves as per Drawing	Drg. No.	37x12x8x9.5mm / 37x12x8x9.5mm	
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		540mm	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 2nd Side One Slot	
15	Tapping Hole Depth		Drill Depth: 28.4mm Tapping Depth: 26.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/10/23

1	As per programme no.			1 Slot 28.1mm width 17mm Depth
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							Raise 10
2	External Relief Dia	6.5mm / 7.0mm	6.5mm All Lines	7.0mm All Lines					
3	External Relief Depth		43mm	15mm					
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	10	23				

Inspected By (Sign) & Date

Ravi 14/10/23

Reviewed by (Engineer-CNC)
Sohy 14/10/23

Manager-QA