

6288



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.		10393 ✓	40/50/70 ✓
2	Machined By		V.T.L H/C Shop	Drill Hole 1.8.0 377
3	Pallet Die No.		10575 (8.0) ✓	Rev E03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 mm / Step 002 697.8 mm Tapper = 5°	
6	Inside Diameter	Drg. No.	548.12 mm	Step length 38.5
7	Width of Pellet Die	Drg. No.	215 mm	Undercut 1.79
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 mm / 29.5 x 10 x 8 mm (6x8) ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Scrap 124
10	Drilling Area Surface Smoothness		ok	Back Side
11	Tapping Operator		N/C Shop	Tapping No of holes 9 Back Side
12	Tapping PCD		618 mm	
13	Tapping Hole Diameter		N/C = Check by H/C Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 32.4 mm	Tapping Depth 32.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/10/23

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

Counting 30°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	8.5 mm / 9.0 mm	8.5 mm	All Lines	9.0 mm				
3	External Relief Depth		30 mm		30 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		19	10	23				

Inspected By (Sign) & Date

Ravi 19/10/23

Sachin 19/10/23

Reviewed by (Engineer-CNC)

Manager-QA