6329

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.		10410	40/65.5
2	Machined By		V.T.L. N/C Shop	Dg No.: L.S.D. 902
3	Pallet Die No.		11163 (8.0) HH	Rev.: 00
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	641.7 HH, Step OD. 652.3 HH	Tapper: 8°
6	Inside Diameter	Drg. No.	508.8 HH / Step ID = 539.7 / 523.3	
7	Width of Pellet Die	Drg. No.	175 HH	Step length 32
8	Grooves as per Drawing	Drg. No.	9x25 HH / 30x21x9 HH	Face Side Step 0.5 Deep
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		N/a Shop	Tapping No. of Holes = 4
12	Tapping PCD		574 HH	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and Third Side Slot	
15	Tapping Hole Depth		Drill Depth 30.4 HH	Tapping Depth = 28.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 27/10/23	
1	As per programme no.		—	A 4 Slot 51.3 HH Long 28 HH width 15.1 HH Deep
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						Rows 8
2	External Relief Dia	9.5 HH	9.5 HH	All Lines				
3	External Relief Depth			25.5 HH				
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	10	23			
	Inspected By (Sign) & Date		Ravi 27/10/23					

Satya 27/10/23
Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner