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.		10539	33/43/66
2	Machined By		V.T.L n/c Shop	Dyn., 18.12.09
3	Pallet Die No.		11189 (6.0) mm	Roo=01
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 mm, Step OD = 699.8 mm	Tapper = 8°
6	Inside Diameter	Drg. No.	548.8 mm	Step length = 31 mm
7	Width of Pellet Die	Drg. No.	194.8 mm	Undercut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32×7×8.1 mm / 32×7×8.1 mm	(4×8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step
10	Drilling Area Surface Smoothness		ok	8 mm Deep Both side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 mm / 618.9 mm	Tapping No
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	of holes = 4
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth = 33.4 mm	Tapping Depth = 31.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 4/11/23	
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

Counter Bo

1	Counter Sinking Depth & Finish	ok						Roo = 12
2	External Relief Dia	6.5mm / 7.3mm	6.5mm All Lines		7.3mm	All Lines		
3	External Relief Depth		3mm			3mm		
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		4	11	23			
	Inspected By (Sign) & Date		Ravi 4/11/23					

Sat 4/11/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner