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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.		10967	35/50/66
2	Machined By		V.T.L. n/c Shop	Qty No. 18.0-809
3	Pallet Die No.		11179 (G.O) n/c	Rev 2.0
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 n/c Step 002 692 n/c	Tapper 8°
6	Inside Diameter	Drg. No.	548.12 n/c	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c	Face side step
9	Fitting Sizes on CNC Plate	Drg. No.	ok	3 n/c Back Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 4
12	Tapping PCD		619 n/c	Both Side
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 34.4 n/c	Tapping Depth 38 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/11/23

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

Counters 30°

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c	All Lines	7.0 n/c	All Lines		
3	External Relief Depth		31 n/c		16 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		22	12	23			

Inspected By (Sign) & Date

Ravi 22/11/23

Reviewed by (Engineer-CNC)
Satyam 22/11/23

Manager-QA