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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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Cneck Parameter	Specification	Observations	Remarks
1	Work Order No.		10945	49/55
2	Machined By		V.T.L n/c Shop	Drg No. 1.S.O. 536
3	Pallet Die No.		11439 (G..) H-H	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	740 H-H / Step 00, 743 H-H	Step length = 27.5
6	Inside Diameter	Drg. No.	630.12 H-H	Under cut = 1.5
7	Width of Pellet Die	Drg. No.	255 H-H	Tapper = 4°
8	Grooves as per Drawing	Drg. No.	22 x 8 x 7 H-H	21.5 x 8.5 x 7 H-H
9	Fitting Sizes on CNC Plate	Drg. No.	ok	22 x 8
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of Holes = 12 Both Side
12	Tapping PCD		685 H-H	
13	Tapping Hole Diameter		M22 - 2 Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 29 H-H	Tapping Depth = 26.8 H-H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 21/1/24

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 H-H	outside (3-3)		Inner				
3	External Relief Depth		19 H-H		13 H-H				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			2	1	24			

Inspected By (Sign) & Date Ravi 21/1/24

Reviewed by (Engineer-CNC)

Manager-QA