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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.		9644 to 9898	35/50/66
2	Machined By		V.T.L. Shop	Dy No. 1-8-02-609
3	Pallet Die No.		10587 (6.0) mm	Rev. 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 mm Step 0.0, 693 mm	Tapper = 8"
6	Inside Diameter	Drg. No.	548.12 mm	Step length = 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Undercut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32x7x8 mm   32x7x8 mm (4x8) mm	Face Side step 2mm Back Both Side
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	
12	Tapping PCD		619 mm	Tapping No of Holes = 4 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 = 33.5 mm Tapping Depth = 31.0	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Raoi 21/7/23

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 = 300

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	6.5 mm   7.0 mm	6.5 mm All Lines	7.0 mm All Lines						
3	External Relief Depth		31 mm	16 mm						
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		7	7	23					

### Inspected By (Sign) & Date

Raoi 21/7/23

Reviewed by (Engineer-CNC)

Manager-QA