

67.31



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.		11007	39/40
2	Machined By		V.T.C. H/C Shop	Reg. No. I.S.No. 959
3	Pallet Die No.		10944(4.0) H/C	Rev. 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C, Step OD: 493 H/C	Step length: 17.5
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	160 H/C	
8	Grooves as per Drawing	Drg. No.	11x5x3 H/C 11x5x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes 8 Both Side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		0.315" - Check by 0.315" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 19.7 H/C	Tapping Depth: 17.2 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 5/1/24

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

Counter: 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 H/C	outside (2-2)		Inner				
3	External Relief Depth		12 H/C		8 H/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			5	1	24			

Inspected By (Sign) & Date

Ravi 5/1/24

Satish 5/1/24

Reviewed by (Engineer-CNC)

Manager-QA