

5774



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.		9646 to 9895	30/50/66
2	Machined By		V.T.L. N/c Shop	Drg No. 1.S.9.609
3	Pallet Die No.		10251 (6.0) N4	Rev 2.0
4	Die Category	Drg. No.	N.7ombo	
5	Out Side Diameter	Drg. No.	680.69 N4 Step 00 = 692.8 N4	Tapper = 8
6	Inside Diameter	Drg. No.	548.12 N4	Step length = 31 N4
7	Width of Pellet Die	Drg. No.	195 N4	Under cut = 2.5 N4
8	Grooves as per Drawing	Drg. No.	32.7 x 8 N4 32.7 x 8 N4	(4x8)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Phase side step 8
10	Drilling Area Surface Smoothness		OK	Deep Back side
11	Tapping Operator		N/c Shop	
12	Tapping PCD		619 N4	Tapping No. of holes = 4
13	Tapping Hole Diameter		MIG = Check by MIG Bit	Back side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 33.3 N4	Tapping Depth = 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rao: 8/2/23

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 = 30

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	6.5 N4 7.0 N4	6.5 N4 All Lines	7.0 N4 All Lines		
3	External Relief Depth		36 N4	16 N4		
4	Inspection Done Before Hardening By (Name)		Rao:			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		8	7	23	

Inspected By (Sign) & Date

Rao: 8/2/23

Reviewed by (Engineer-CNC)

Manager-QA