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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.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11054	42/50
2	Machined By		V.T.L H/c Shop	Drg No. L.S.D. 71
3	Pallet Die No.		11446 (4.0) mm	Rev. no.
4	Die Category	Drg. No.	Extrusion die	
5	Out Side Diameter	Drg. No.	620mm, Step 002 622.4mm / 622mm	Tapping 12
6	Inside Diameter	Drg. No.	520.14mm	Step length 17mm
7	Width of Pellet Die	Drg. No.	222mm	Under cut 1.2mm
8	Grooves as per Drawing	Drg. No.	9x10x4mm / 9x10x4mm	1mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping dia of Holes = 12 Back Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		H20 - Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.4mm	Tapping Depth 19mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/1/24

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					Counters 60°
2	External Relief Dia	4.3mm	Outside 3-3)	Inner			Rev 2 32
3	External Relief Depth		12mm	8mm			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		13	1	24		

Inspected By (Sign) & Date

Ravi 13/1/24

Reviewed by (Engineer-CNC)

Manager-QA