

5773



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	30/50/60
2	Machined By		V.T.L. w/c Shop	Dy. No. S.D. 609
3	Pallet Die No.		10250 (6.0) mm	Rec. 201
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 mm	Step 8°
6	Inside Diameter	Drg. No.	548.12 mm	Step length = 31 mm / 31.2
7	Width of Pellet Die	Drg. No.	195 mm	Under cut = 2.45 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 mm / 32 x 7 x 8 mm (4 x 8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side step
10	Drilling Area Surface Smoothness		OK	Deep Both side
11	Tapping Operator		w/c Shop	
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	Tapping No. of Holes = 4 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 33.3 mm	Tapping Depth = 31.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 8/7/23

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 = 30

1	Counter Sinking Depth & Finish	OK							Row = 12
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm All Lines	7.0 mm All Lines					
3	External Relief Depth		36 mm	16					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		8	7	23				

Inspected By (Sign) & Date

Ravi 8/7/23

Reviewed by (Engineer-CNC)

Manager-QA