

6.780

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.		11014	45/621
2	Machined By		V.T.L. N/C Shop	Drig Nos 1.8.0.584
3	Pallet Die No.		10381 (8.0) H4	Rev 02 of
4	Die Category	Drg. No.	Tombo	
5	Out Side Diameter	Drg. No.	780 H4 Step OD = 798 H4	Step length = 25.5
6	Inside Diameter	Drg. No.	660.12 H4	Taper = 4°
7	Width of Pellet Die	Drg. No.	324 H4	Under cot = 9 H4
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 H4 / 21.5 x 8 x 10 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No of Holes = 12 Botu Side
12	Tapping PCD		725 H4	
13	Tapping Hole Diameter		M2 = Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 31.4 H4 Tapping Depth = 28.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/1/24

1	As per programme no.			2 Slot 32.1 H4 width 2 H4 Deep Botu Side
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				Counter = 6°
2	External Relief Dia	8.5 H4	outside (3-3)	Inner		Low = 27
3	External Relief Depth	✓	23 H4	15 H4		
4	Inspection Done Before Hardening By (Name)		Ravi			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		15	1	24	

Inspected By (Sign) & Date

Ravi 15/1/24

Reviewed by (Engineer-CNC)

Manager-QA