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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

Rev. Date 31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10954	19/09/09
2	Machined By		V.T.L. n/c Shop	21/31/09
3	Pallet Die No.		11135(6.0)mm	Die No. 18.02.203
4	Die Category	Drg. No.	M. Jumbo	Rev: 00
5	Out Side Diameter	Drg. No.	838 mm, Step OD = 848 mm	Tap size 5"
6	Inside Diameter	Drg. No.	700.12 mm / 700.14 mm	Step length = 38.5
7	Width of Pellet Die	Drg. No.	240 mm	Under cut = 1.25 mm
8	Grooves as per Drawing	Drg. No.	29x10x8 mm / 29x10x8 mm	(8x8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Hole: 9 ✓ Both Side
12	Tapping PCD		765 mm	
13	Tapping Hole Diameter		MIG = Check by MIG Bell	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 mm	Tapping Depth = 30.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 22/1/24*

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	
2	External Relief Dia	1st Pad 7.0 mm 50 mm 7.5 mm 40 mm	2nd Pad 8.5 mm 48 mm 7.5 mm 38 mm
3	External Relief Depth		
4	Inspection Done Before Hardening By (Name)		Ravi
5	Material Sent For Hardening By (Name)		Lark Furnace
6	Material Sent For Hardening On Date	22	24

Inspected By (Sign) & Date *Satya 22/1/24* *Ravi 22/1/24*

Reviewed by (Engineer-CNC)

Manager-QA