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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.		11312	30/45
2	Machined By		V.T.L. H/C Shop	Drg. No. 1.20.14949
3	Pallet Die No.		10488 (4.0) H/C	Rev. 2.0
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510 H/C Step OD = 491 H/C	Step length = 17.4
6	Inside Diameter	Drg. No.	480.12 H/C	
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C / 12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H/C of Holes = 8 Both Side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		H2 = Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 19 H/C Tapping Depth = 17.3	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 20/7/24

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

Counters 60°

1	Counter Sinking Depth & Finish	OK							low = 20
2	External Relief Dia	4.5 H/C	Outside (3-3)		Inner				
3	External Relief Depth		19 H/C		15 H/C				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date								20 2 24

Inspected By (Sign) & Date

Ravi 20/7/24

Reviewed by (Engineer-CNC)