

7055



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.		10583 10583	35/45/60
2	Machined By		V.T.L. H/C Shop	Dy. No. 12.02.169
3	Pallet Die No.		11787 (4.0) H/C	Rev. 08
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/C, Step 602 932 H/C	Step 190 / 718 H/C
6	Inside Diameter	Drg. No.	660.14 H/C	10 Step length 10 ¹⁰ 670.12 H/C
7	Width of Pellet Die	Drg. No.	331.4 H/C	Step length 30 H/C
8	Grooves as per Drawing	Drg. No.	46x7x9.5 H/C	10-36x7x9.5 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
12	Tapping PCD		785 H/C	of holes 4
13	Tapping Hole Diameter		M20x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and Third Side 3 Slot	
15	Tapping Hole Depth		Drill Depth 31 H/C	Tapping Depth 28.6 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 5/3/24

1	As per programme no.			3 Slot
2	Gun Drilling Work Completed On			37.1 H/C width
3	Hole Finish In Gun Drilling	Marked	ok	20.5 H/C Depth
4	Defective Holes (If Any)		No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.3 H/C / 4.8 H/C	4.3 H/C All Rows		4.8 H/C All Rows					
3	External Relief Depth		25 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		5	3	24					

Inspected By (Sign) & Date

Ravi 5/3/24

Reviewed by (Engineer-CNC)
Satsar 5/3/24

Manager-QA