

7069



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.		11389	36/66
2	Machined By		V.T.L. H/C Shop	Drg. No. I.S.O. 609
3	Pallet Die No.		11911 (10.0) H/C	Rev. 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H/C Step 00, 693 H/C	Tapper 8°
6	Inside Diameter	Drg. No.	548.12	Step length 31 H/C
7	Width of Pellet Die	Drg. No.	195 H/C	Undercut 2.5 H/C
8	Grooves as per Drawing	Drg. No.	32x7x8 H/C 32x7x8 H/C (4x8) H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Face Side Step 2 H/C [Deep Back Side Tapping No. of Holes 4 Back Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 H/C	
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 334 H/C	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date *Ravi 31/3/24*

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 *Counter 60*

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	11.0 H/C	All	Round					
3	External Relief Depth			30 H/C					
4	Inspection Done Before Hardening By (Name)								<i>Ravi</i>
5	Material Sent For Hardening By (Name)								<i>Lark Furnace</i>
6	Material Sent For Hardening On Date		7	3	24				

Inspected By (Sign) & Date *Ravi 31/3/24*

Satyam
 31/3/24
 Reviewed by (Engineer-CNC)

Manager-QA