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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11396/	96/36/55/
2	Machined By		V.T.L H/c Shop	Dry H/c 1.8.02 340
3	Pallet Die No.		11113(6.0) H/c	Rev 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	689.7 H/c Step 00 - 68.7	Tapber 12°
6	Inside Diameter	Drg. No.	580.12 H/c	Step length 34.5
7	Width of Pellet Die	Drg. No.	266 H/c	
8	Grooves as per Drawing	Drg. No.	28.5 x 6 x 12 H/c 28.5 x 6 x 8 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No of Holes = 12 Both Side
12	Tapping PCD		630 H/c	
13	Tapping Hole Diameter		H/c Check by H16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 25.8 H/c	Tapping Depth 28.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/3/24

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

1	Counter Sinking Depth & Finish	ok								Row 2 25
2	External Relief Dia	6.5 H/c 7.0 H/c	6.5 H/c All Rows	7.0 H/c All Rows						
3	External Relief Depth		22	19 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		14	3	24					

Inspected By (Sign) & Date

Ravi 14/3/24

Reviewed by (Engineer-CNC)
Satsar 14/3/24

Manager-QA