

7092



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.		11386	40/55
2	Machined By		V. T. L. N/C Shop	Drg No. 18.02.557
3	Pallet Die No.		11025 (3.0) mm	Rev. 00
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	630mm, Step 002 624mm	Tapber 12°
6	Inside Diameter	Drg. No.	520.14mm	Step length 20mm
7	Width of Pellet Die	Drg. No.	182mm	
8	Grooves as per Drawing	Drg. No.	12x10x5mm 12x10x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8mm Tapping Depth 18.8mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 13/3/24

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	8.3mm	outside (3.3)		Inner				
3	External Relief Depth		93mm		15mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		13	3	24				

Inspected By (Sign) & Date Ravi 13/3/24

Sethi
13/3/24
Reviewed by (Engineer-CNC)

Manager-QA