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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.		11322	28/38/66
2	Machined By		N. T. L. H/O Shop	Drg No. 1-8.0-609
3	Pallet Die No.		11921 (6.0) H/H	Rev 2.01
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/H / Step 02 = 693 H/H	Tabber 8°
6	Inside Diameter	Drg. No.	548.14 H/H	Step length 31 H/H
7	Width of Pellet Die	Drg. No.	195 H/H	Under cut = 2.5 H/H
8	Grooves as per Drawing	Drg. No.	32+7+8 H/H / 32+7+8 H/H	(C/S)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step 3 H/H
10	Drilling Area Surface Smoothness		OK	Back Side
11	Tapping Operator		H/O Shop	Tapping No. of Holes 4 Back Side
12	Tapping PCD		319 H/H	
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 33.8 H/H	Tapping Depth 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 15/3/24

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					Counter 30°
2	External Relief Dia	6.5 H/H / 7.0 H/H	6.5 H/H All Rows	7.0 H/H All Rows			Row 2 12
3	External Relief Depth		38 H/H	28 H/H			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Porrace				
6	Material Sent For Hardening On Date		15	3	24		

Inspected By (Sign) & Date Ravi 15/3/24

Reviewed by (Engineer-CNC) Satya 15/3/24

Manager-QA