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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
 Rev. Date 31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11399 ✓	36/66
2	Machined By		V.T.L. H/c Shop	Drg No. 18.0 609
3	Pallet Die No.		11913 (10.0) ✓	Revered
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm ✓	693 mm Tappers 8°
6	Inside Diameter	Drg. No.	548.14 mm (B)	Step length 5 mm
7	Width of Pellet Die	Drg. No.	195 mm ✓	Under cut 9.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 mm 32 x 7 x 8 mm ✓	4 x 8 mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step 2 mm
10	Drilling Area Surface Smoothness		ok	Deep Both Side
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		619 mm ✓	of Hole 4
13	Tapping Hole Diameter		H16 ✓	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.7 mm ✓	Tapping Depth 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/8/24

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 600
2	External Relief Dia	11.0 mm ✓	All Rows						Row 2 B
3	External Relief Depth		30 mm ✓						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		18	3	24				

Inspected By (Sign) & Date

Ravi 18/8/24

Reviewed by (Engineer-CNC)

Manager-QA