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.		11630/	98/38/GS /
2	Machined By		V.T.L. N/C Shop	Dwg No. 1.3.D.509 Rev: 01
3	Pallet Die No.		11917 (6.0) HH/	
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 HH, Step OD: 693 HH	Tapper 3°
6	Inside Diameter	Drg. No.	548.14 HH (A)	Step length 31 HH Undercut 2.5 HH
7	Width of Pellet Die	Drg. No.	195 HH	
8	Grooves as per Drawing	Drg. No.	32x7x8 HH / 32x7x8 HH (4x2) HH,	Face Side Step 2 HH Both Side
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, 4 Both Side
12	Tapping PCD		619 HH/	
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. 33.7 HH	Tapping Depth. 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 22/3/24	
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° Rows-12
2	External Relief Dia	6.5HH / 7.0HH	6.5HH	All Rows	7.0HH	All Rows		
3	External Relief Depth	✓	28 HH			28 HH		
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		22	3	24			
	Inspected By (Sign) & Date		Ravi 22/3/24					

Satya 27/3/24

Viewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner