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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.		11580	40/55
2	Machined By		V. T. L. n/c Shop	Day No. 13.0.526
3	Pallet Die No.		11438 (4.0) mm	Rev. 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	740 mm, Step 00 = 743 mm	Tappet 4°
6	Inside Diameter	Drg. No.	630.12 mm	Step length 27.5
7	Width of Pellet Die	Drg. No.	255 mm	100 exact, 1.5 mm
8	Grooves as per Drawing	Drg. No.	22x8x7 mm 22x8x7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes of holes 12 Both Side
12	Tapping PCD		685 mm	
13	Tapping Hole Diameter		M22 - Check by M22 Roll	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 29 mm Tapping Depth 26.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/4/24

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 60°
2	External Relief Dia	4.5 mm	outside (3-3)		Inner		Ravi 31
3	External Relief Depth		19 mm		15 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		B	4	24		

Inspected By (Sign) & Date

Ravi 31/4/24

Reviewed by (Engineer-CNC)
Sotom 31/4/24

Manager-QA