

7249



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.		11648	40/48/55
2	Machined By		V.T.L. H/c Shop	Dry H. L.S. 02 G.C.C
3	Pallet Die No.		12139 (G.O.) H/H	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710 H/H, Step OD = 692.8 H/H	Tapper 12°
6	Inside Diameter	Drg. No.	600.12 H/H	Step length 25 H/H
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 H/H / 12x10x7.5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of holes = 12 Back Side
12	Tapping PCD		640 H/H	
13	Tapping Hole Diameter		H20 - Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.7 H/H	Tapping Depth 18.7
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 Counter, Go

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	6.5 H/H / 7.0 H/H	6.5 H/H All Rows	7.0 H/H All Rows						
3	External Relief Depth	-	15 H/H	7 H/H						
4	Inspection Done Before Hardening By (Name)		Ravi							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		3	4	24					

Inspected By (Sign) & Date Ravi 31/4/24

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

Manager-QA