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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.		11411	53/66
2	Machined By		V.T.L H/c Shop	50/66
3	Pallet Die No.		11914 (10.0) H/H	Dy No. 12.9.2009
4	Die Category	Drg. No.	M. Jumbo	Revised
5	Out Side Diameter	Drg. No.	680.7 H/H Step OD: 693 H/H	Tapper 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 x 7 x 8 H/H   32 x 7 x 8 H/H	(4 x 8) H/H
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step 2 H/H
10	Drilling Area Surface Smoothness		ok	Deep Back Side
11	Tapping Operator		H/c Shop	Tapping No of Holes, 4 Back Side
12	Tapping PCD		619 H/H	
13	Tapping Hole Diameter		H16 - Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.7 H/H	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/4/24

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

Capitan 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	11.5 H/H	1st Pad	2nd Pad					
3	External Relief Depth		8 H/H	8 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		4	4	24				

Inspected By (Sign) & Date

Ravi 4/4/24

Satish 4/4/24

Reviewed by (Engineer-CNC)

Manager-QA