

7272



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.		11702	34/50
2	Machined By		V.T.L.H.C. Shop	Dry Hole 1.8.0. 633
3	Pallet Die No.		11406 (4.0)H4	Rev. 01
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	620.1 H4, Step OD: 623.6 H4	Tapping 12"
6	Inside Diameter	Drg. No.	520.14 H4 (A)	Step length 20 H4
7	Width of Pellet Die	Drg. No.	186 H4	Under cut 1.8 H4
8	Grooves as per Drawing	Drg. No.	13x8x5 H4 / 13x8x5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		HLC Shop	Tapping No of Holes 12 Back Side
12	Tapping PCD		565 H4	
13	Tapping Hole Diameter		HLC, Check by HLC Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.8 H4	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/4/24

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 Dias 2.25
2	External Relief Dia	4.5 H4	20 Side (3-3)	Inner			
3	External Relief Depth		20 H4	16 H4			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		8	4	24		

Inspected By (Sign) & Date

Ravi 8/4/24

Reviewed by (Engineer-CNC)
8/4/24

Manager-QA