

7275



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.		11985	50/65.5
2	Machined By		V.T.G n/c Shop	Dry No. 1.S.O. 902
3	Pallet Die No.		11157 (10.0) n/c	Rev 2.00
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	640.2 n/c Step OD = 641.7 n/c	650.3 n/c
6	Inside Diameter	Drg. No.	508.1 n/c (A)	Step length = 32 n/c
7	Width of Pellet Die	Drg. No.	175.1 n/c	Tappers = 2°
8	Grooves as per Drawing	Drg. No.	30x31x8.3 n/c 10x24 n/c	Undercut = 0.8
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
12	Tapping PCD		574 n/c	
13	Tapping Hole Diameter		MIG = Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and	2nd side 4 slot
15	Tapping Hole Depth		Drill Depth = 31 n/c	Tapping Depth = 28.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 8/4/24	4 slot 51.5 n/c long 28 n/c wide 15 n/c depth
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° Rev 2.6
2	External Relief Dia	11.0 n/c	All Rows	
3	External Relief Depth		15.5 n/c	
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)

Manager-QA