

7476



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.		11870	410/60
2	Machined By		V.T.L. H/C Shop	Dy No. 1.5.0.584
3	Pallet Die No.		12303 (6-0) mm	Rev. 01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 mm, Step OD, 798 mm	Tappers 4
6	Inside Diameter	Drg. No.	660.12 mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	394 mm	Width cut 9 mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 mm 21.5 x 8 x 10 mm	
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 212 Both Side
12	Tapping PCD		725 mm	
13	Tapping Hole Diameter		M20, Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 31 mm	Tapping Depth 28.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 13/5/24	2 Slot
1	As per programme no.		_____	32.1 mm width 8 mm Deep Both Side
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 Ras = 34
2	External Relief Dia	6.5 mm	outside (2-3)	Inner
3	External Relief Depth		26 mm	20 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		13 5 24	
Inspected By (Sign) & Date			Ravi 13/5/24	

Reviewed by (Engineer-CNC)

Manager-QA