

7474



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.		11941	28/36/66
2	Machined By		V.T.L. H/C Shop	Drg No. U.92609
3	Pallet Die No.		12248 (8.0) H/C	Revised
4	Die Category	Dr. No.	M-Tumbo	
5	Out Side Diameter	Dr. No.	680.7 H/C Step 00, 693 H/C	Tapper = 8°
6	Inside Diameter	Dr. No.	548.12 H/C	Step length = 20.9 H/C
7	Width of Pellet Die	Dr. No.	194.8 H/C	Undercut = 9.5 H/C
8	Grooves as per Drawing	Dr. No.	32 x 7 x 8 H/C 32 x 7 x 8 H/C (4 x 3)	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	[Fore Side Step H/C]
10	Drilling Area Surface Smoothness		ok	[Deep Both Side]
11	Tapping Operator		H/C Shop	[Tapping H/C]
12	Tapping PCD		619 H/C	[of holes = 4]
13	Tapping Hole Diameter		MIS = Check by M16 Bolt	[Both Side]
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 H/C	Tapping Depth = 31.1
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 13/5/24

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 = 30

1	Counter Sinking Depth & Finish	ok						Raw: 10
2	External Relief Dia	8.5 H/C 9.0 H/C	8.5 H/C All Rows	9.0 H/C All Rows				
3	External Relief Depth		4.0 H/C		3.0 H/C			
4	Inspection Done Before Hardening By (Name)		Raw					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		13	5	24			

Inspected By (Sign) & Date

Raw: 13/5/24

Reviewed by (Engineer-CNC)

Manager-QA