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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

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11969	33/66
3	Pallet Die No.		V.T.L. n/c Shop	Drg No. 18.0.0.9
4	Die Category	Drg. No.	12281 (G.O) n/c	Revol
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.7 mm Step 90 = 692 mm	Tabber = 2"
7	Width of Pellet Die	Drg. No.	548.12 mm	Step length = 31 mm
8	Grooves as per Drawing	Drg. No.	195 mm	Under cut = 2.5 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 8 mm 32 x 7 x 8 mm (1 x 2)	Face Side Step 2 mm
10	Drilling Area Surface Smoothness		ok	Back Side 2 mm
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 4 Both Side
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 mm	Tapping Depth = 30.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rao: 15/5/24

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

1	Counter Sinking Depth & Finish	ok					Count = 60
2	External Relief Dia	1.5 mm	1.5 mm	All Rows			Rep - 12
3	External Relief Depth			33 mm			
4	Inspection Done Before Hardening By (Name)						Rao
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		15	5	24		

Inspected By (Sign) & Date

Rao: 15/5/24

Reviewed by (Engineer-CNC)

Manager-QA