

7498



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.		11955	
2	Machined By		V.T.L. n/c Shop	34/50
3	Pallet Die No.		12186 (4.0) n/c	8335 Dy. n/c work 8810
4	Die Category	Drg. No.	Extr. profile	
5	Out Side Diameter	Drg. No.	62mm Step OD = 61.2mm	Step length = 17.5
6	Inside Diameter	Drg. No.	520.12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565mm	Tapping No. of Holes = 12 Both Side
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 = 20.8mm	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raoi 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								Counter 6° 2022 31
2	External Relief Dia	4.5mm	Outside (3-3)	Inner						
3	External Relief Depth		2mm	16mm						
4	Inspection Done Before Hardening By (Name)		Raoi							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		15	5	24					

Inspected By (Sign) & Date

Raoi 15/5/24

Reviewed by (Engineer-CNC)
Sats 15/5/24

Manager-QA