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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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9613	38/45
2	Machined By		V.T.L. n/c Shop	Drg No. 15430
3	Pallet Die No.		10565 to 566 (3.0) mm	Rev 2.00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	610mm Step OD = 612mm	Step length 2mm
6	Inside Diameter	Drg. No.	580.1mm	Under cut = 1mm
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	Tapping no of holes 12 Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		Map 2 Check by Map Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 2.5mm	Tapping Depth = 8mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Res: 3/6/23

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							Res: 38
2	External Relief Dia	3.5mm	outside (3-3)		Inner				
3	External Relief Depth		14mm		7mm				
4	Inspection Done Before Hardening By (Name)								Res: ✓
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		3	6	23				

Inspected By (Sign) & Date

Res: 3/6/23

3/6/23

Reviewed by (Engineer-CNC)

Manager-QA