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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.		9613	36/45
2	Machined By		N.T.L. H/c Shop	Drill No. 1-8-C-15430
3	Pallet Die No.		10566 10565 (3-0) H/c	Revised
4	Die Category	Drg. No.	Fullsize	
5	Out Side Diameter	Drg. No.	610 H/c Step 00, 611.8 H/c	Step length 20 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	Under cut 2 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
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: 12 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20 + Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.4 H/c	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 31/6/23	
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		Rev 2 28
2	External Relief Dia	3.5 H/c	outside (3-3)	Inner
3	External Relief Depth		15 H/c	9 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark furnace	
6	Material Sent For Hardening On Date		3 6 23	
Inspected By (Sign) & Date			Ravi 31/6/23	

Reviewed by (Engineer-CNC)

Manager-QA