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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.		9348 to 9748	35/50
2	Machined By		V. T. G. H/C Shop	Dry No. 1-25-9980
3	Pallet Die No.		10143 (3.5) mm	Recess
4	Die Category	Drg. No.	Front side	
5	Out Side Diameter	Drg. No.	620 mm Step 002 Tapper 12	Step length 18
6	Inside Diameter	Drg. No.	520.12 mm	
7	Width of Pellet Die	Drg. No.	228 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
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 Back Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 6/6/23

1.	As per programme no.		<u> </u>
2	Gun Drilling Work Completed On		<u> </u>
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								Ravi 35
2	External Relief Dia	3.8 mm	20 Side 3-3		Inner					
3	External Relief Depth		18 mm		15 mm					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date			6	6	23				

Inspected By (Sign) & Date Ravi 6/6/23

Reviewed by (Engineer-CNC)

Manager-QA