

5985



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.		10123	46/50
2	Machined By		V.T.L n/c Shop	Dry No. 1.3.0-742
3	Pallet Die No.		10876 (8.0) n/c	Rev 2.00
4	Die Category	Drg. No.	Senior	✓
5	Out Side Diameter	Drg. No.	5.20 n/c Step 002 498 n/c	Step Length 17.5
6	Inside Diameter	Drg. No.	4.20.12 n/c	
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 12x8x3 n/c	
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 8 Both Side
12	Tapping PCD		454 n/c	
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 18.4 n/c Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/8/23

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								Ravi 12
2	External Relief Dia	8.5 n/c	Outside (2-2)		Inner					
3	External Relief Depth		1.2 n/c		4 n/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Porrace
6	Material Sent For Hardening On Date		23	8	23					

Inspected By (Sign) & Date

Ravi 23/8/23

Reviewed by (Engineer-CNC)

Manager-QA