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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.		10148	42/50
2	Machined By		V.T.L n/c Shop	By Nee.20-998
3	Pallet Die No.		10597 (4.0) n/c	Rev 2.00
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	620.1 n/c Step 002 Tapp 12" Step 1.8"	
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 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 holder 12 Both Side
12	Tapping PCD		585 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 20.4 n/c Tapping Depth 18.8"	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rasi 25/8/23

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							
2	External Relief Dia	4.5 n/c	Outside (3-3)	Inner					Rev 2.31
3	External Relief Depth	✓	12 n/c	8 n/c					
4	Inspection Done Before Hardening By (Name)								Rasi
5	Material Sent For Hardening By (Name)								Lark Engineere
6	Material Sent For Hardening On Date		25	23					

Inspected By (Sign) & Date

Rasi 25/8/23

Reviewed by (Engineer-CNC)

Manager-QA