

6013



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.		10158	20/35/60 ✓
2	Machined By		V.T.L n/c Shop	Dr No. 1-302 11
3	Pallet Die No.		10823 (G.O) n/c/65(2-2)	Rev. 00 ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 n/c Shop 002 792 n/c	Step length 6.5
6	Inside Diameter	Drg. No.	660.12 n/c	Under cut 2 G n/c ✓
7	Width of Pellet Die	Drg. No.	320 n/c	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 n/c 21.5 x 8 x 8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		725 n/c	Tapping No. of holes 12 Bottom side ✓
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 31.4 n/c Tapping Depth 29.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/8/23

1	As per programme no.			2 Slot 32.1 n/c wide 8 n/c Deep Bottom side ✓
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						Pop = 31
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c All Lines (2-2)	7.0 n/c All Lines				
3	External Relief Depth		4.0 n/c	2.5 n/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		29	28	23			

Inspected By (Sign) & Date

Ravi 29/8/23

Reviewed by (Engineer-CNC)

Manager-QA