

6091



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.		10306	40/50
2	Machined By		V.T.L. n/c Shop	Dry No. 1.8.0.125-1
3	Pallet Die No.		9836 (3.5) n/c	Revol
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c Step 0.02 693 n/c	Step length 2 n/c
6	Inside Diameter	Drg. No.	600.12 n/c	Tappers 12°
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x7 n/c 12x8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping n/c of holes 12 Botu Side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		N20 Check by N20 Ball	
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 Ravi 9/9/23

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 35
2	External Relief Dia	4.0 n/c	outside (3.3)		Inner					
3	External Relief Depth		17 n/c		10 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			9	9	23				

Inspected By (Sign) & Date Ravi 9/9/23

Reviewed by (Engineer-CNC) 9/9/23

Manager-QA