6023

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.		10136	120/120
2	Machined By		V.T.L H/C Shop	Dwg No. L.3.0.559 Rev 2
3	Pallet Die No.		1046 (3.5) MM	
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	870 MM Step OD 743.5 MM	Tapper 10°
6	Inside Diameter	Drg. No.	630.12 MM	Step Length 93 MM
7	Width of Pellet Die	Drg. No.	265 MM	
8	Grooves as per Drawing	Drg. No.	15x8x5 MM / 15x8x5 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 16 Both Side
12	Tapping PCD		685 MM	
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 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 2/9/23	
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 - 3 Hole Coloured (B)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	Ok						Ravi 40
2	External Relief Dia	—	—	No	—	Relief		
3	External Relief Depth		—	—	—	—		
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Keshav					
6	Material Sent For Hardening On Date		2	9	23			
	Inspected By (Sign) & Date		Ravi 9/9/23					

2/9/23

ved by (Engineer-CNC)

Manager-QA

Scanned with CamScanner