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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
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10012	34/44/55
2	Machined By		V.T.L. n/c Shop	Drg No. 1.3.02.48
3	Pallet Die No.		10023 (4.0) n/c	Rev. 00
4	Die Category	Drg. No.	N. Jumbo	✓
5	Out Side Diameter	Drg. No.	710 n/c Step OD = 392 n/c	Step length = 19.5
6	Inside Diameter	Drg. No.	800.12 n/c	✓
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 n/c / 12.5 x 8 x 7 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 = 12 Both side
12	Tapping PCD		645 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 = 22.5 n/c	Tapping Depth = do. 2
16	Perpendicularity of Tapped Hole		yes	✓
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 11/9/23

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 - 2 Hole Closed (D)

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

1	Counter Sinking Depth & Finish	ok								Ravi 32
2	External Relief Dia	4.5 n/c / 5.0 n/c	4.5 n/c All Lines	/	5.0 n/c All Lines					
3	External Relief Depth		2 n/c	/	1 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		11	9	23					

Inspected By (Sign) & Date Ravi 11/9/23

Reviewed by (Engineer-CNC) [Signature] 11/9/23

Manager-QA