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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.		9659	28/40
2	Machined By		V.T.L n/c Shop	Drg No. L.S.D = 332
3	Pallet Die No.		9785 (2.8) n/c	Rear od
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c Step 00 = 499 n/c	Tapper = 12"
6	Inside Diameter	Drg. No.	480.12 n/c	Step length = 20"
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x8x3 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 = 8 Both Side
12	Tapping PCD		454 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 = 18.4 n/c	Tapping Depth = 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/6/23

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 Colused (A)

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

1	Counter Sinking Depth & Finish	ok							Rep = 26
2	External Relief Dia	3.3 n/c	outside (2-2)		Inner				
3	External Relief Depth	✓	15 n/c		12 n/c				
4	Inspection Done Before Hardening By (Name)		✓						
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			19	6	23			

Inspected By (Sign) & Date

Ravi 19/6/23

Reviewed by (Engineer-CNC)

Manager-QA