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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.		10484 ✓	35/45 ✓
2	Machined By		V.T.L. n/c Shop	Dy No. 1.8029747
3	Pallet Die No.		9831 (B.O) ✓	Revised ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	690 ✓	Step 693 ✓
6	Inside Diameter	Drg. No.	600.12 ✓	Step length 20 ✓
7	Width of Pellet Die	Drg. No.	222 ✓	Under cut 1.5 ✓
8	Grooves as per Drawing	Drg. No.	14x8x7 ✓	
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 Rada Side
12	Tapping PCD		640 ✓	
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 28.4 ✓	Tapping Depth 28.7 ✓
16	Perpendicularity of Tapped Hole		yes ✓	
17	Visual Inspection Before Gun Drilling		OK ✓	

Inspected By (Sign) & Date

Raoi 18/10/23

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 ✓								
2	External Relief Dia	3.5 ✓	outside (2-3)			Inner				
3	External Relief Depth		16 ✓			10 ✓				
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date				18	10	23			

Inspected By (Sign) & Date

Raoi 18/10/23

Reviewed by (Engineer-CNC)
Sahu 18/10/23

Manager-QA