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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.		10488	410/50
2	Machined By		V.T.L n/c Shop	Drg No. 1.8.02/2614
3	Pallet Die No.		8824 (3.0) n/c	Rev 2.00
4	Die Category	Drg. No.	NJ920	
5	Out Side Diameter	Drg. No.	700 n/c, Step OD = 692 n/c	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 n/c	
7	Width of Pellet Die	Drg. No.	965 n/c	
8	Grooves as per Drawing	Drg. No.	15x8x7 n/c 15x8x7 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		640 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 20.4 n/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/10/23

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 - 1 Hole Closed

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

1	Counter Sinking Depth & Finish	ok									Ravi 47
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner						
3	External Relief Depth		16 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		23	10	23						

Inspected By (Sign) & Date

Ravi 31/10/23

Reviewed by (Engineer-CNC)
 S. Chatterjee
 23/10/23

Manager-QA