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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.		10504 ✓	30/38/60
2	Machined By		V.T.L. H/c Shop	Drg No. 1.3.0.797
3	Pallet Die No.		10996 (4.0) H/c	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/c / Step 00. 798 H/c	Step length 28.5
6	Inside Diameter	Drg. No.	660.12 H/c	Under cut 6 H/c
7	Width of Pellet Die	Drg. No.	324 H/c	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 H/c / 21.5 x 8 x 8 H/c	
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: 12 Both Side
12	Tapping PCD		785 H/c ✓	
13	Tapping Hole Diameter		M202 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 31.3 H/c	Tapping Depth 29.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 18/11/23	
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		Counter 30
2	External Relief Dia	4.5 H/c / 5.0 H/c	4.5 H/c All Lines 5.0 H/c All Lines	Rev 2.42
3	External Relief Depth		30 H/c 30 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		18 11 23	
Inspected By (Sign) & Date			Ravi 18/11/23	

Reviewed by (Engineer-CNC)

Manager-QA