

6327



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.			
2	Machined By		10419	30/40/65.5
3	Pallet Die No.		N.T.L n/c Shop	Drg No. 1-3.02 909
4	Die Category	Drg. No.	11153 (8.0) n/c	Recess
5	Out Side Diameter	Drg. No.	55370	
6	Inside Diameter	Drg. No.	641.7 n/c Step 00 - 652.3 n/c	Tap 2 3°
7	Width of Pellet Die	Drg. No.	508.8 n/c Step 10 = 539.7 / 533.2 n/c	Step length = 32
8	Grooves as per Drawing	Drg. No.	175 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	9x25 n/c / 30x21x9 n/c	Face side Step 0.5
10	Drilling Area Surface Smoothness		ok	Deep
11	Tapping Operator		n/c Shop	
12	Tapping PCD		574 n/c	Tapping No of holes: 4
13	Tapping Hole Diameter		M16 2 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and	Third side Slot
15	Tapping Hole Depth		Drill Depth = 30.4 n/c	Tapping Depth = 28.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/10/23

1	As per programme no.			4 slot
2	Gun Drilling Work Completed On			51.2 mm long
3	Hole Finish In Gun Drilling	Marked	ok	28 mm width
4	Defective Holes (If Any)		No	15.1 mm Deep

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

1	Counter Sinking Depth & Finish	ok							Recess
2	External Relief Dia	8.5 n/c / 9.5 n/c	8.5 n/c All Lines	9.5 n/c All Lines					
3	External Relief Depth	-	29.5 n/c	19.5 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		27	10	23				
Inspected By (Sign) & Date		Ravi 27/10/23							

Reviewed by (Engineer-CNC)
Soh 27/10/23

Manager-QA