

6338



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.		10508	33/40
2	Machined By		V. T. L. H/C Shop	Drg No. 1.S.D. 495
3	Pallet Die No.		10344 (3.0) H/C	Rev. 00
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	500 H/C	Step 00. 491 H/C
6	Inside Diameter	Drg. No.	420.12 H/C	Step length. 19.5
7	Width of Pellet Die	Drg. No.	173 H/C	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 H/C / 10x8.5x5 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 = 8 Both Side
12	Tapping PCD		455 H/C / 454.9 H/C	
13	Tapping Hole Diameter		03/4" Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.8 H/C	Tapping Depth. 19 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/10/23

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								Ravi 28
2	External Relief Dia	3.3 H/C	Outside (2-2)		Inner					
3	External Relief Depth		13 H/C		7 H/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		28	10	23					

Inspected By (Sign) & Date

Ravi 28/10/23

Reviewed by (Engineer-CNC) Sats 28/10/23

Manager-QA