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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.		10464	45/60
2	Machined By		V.T.L. n/c Shop	Drg No. 13.0.408
3	Pallet Die No.		10908 (8.0) n/c	Rev 200
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	7.20 n/c	Step OD = 693 n/c
6	Inside Diameter	Drg. No.	600.12 n/c	Tabber = 12
7	Width of Pellet Die	Drg. No.	222 n/c	Step length = 20 n/c
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 7 n/c	
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		M202 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 = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/10/23

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 18
2	External Relief Dia	8.5 n/c	Outside (3-3)		Inner					
3	External Relief Depth		23 n/c		15 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 22/10/23

Reviewed by (Engineer-CNC)
Sahjan 22/10/23

Manager-QA