

6345



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.		10612 ✓	33/50
2	Machined By		V.T.L. n/c Shop	Dy. No. 12013780
3	Pallet Die No.		10061 (G.O) n/c ✓	Rev. 00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c / Step 00, 491 n/c	Step length 17.5 ✓
6	Inside Diameter	Drg. No.	420.12 n/c ✓	
7	Width of Pellet Die	Drg. No.	158 n/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x8x3 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 = 8 Both Side
12	Tapping PCD		454 n/c ✓	
13	Tapping Hole Diameter		n/c = Check by n/c B.O. ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 n/c	Tapping Depth 16.8 ✓
16	Perpendicularity of Tapped Hole		yes ✓	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Raoi 30/10/23	
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		Pass = 15
2	External Relief Dia	6.5 n/c	Outside (2-2)	Inner
3	External Relief Depth		23 n/c	17 n/c
4	Inspection Done Before Hardening By (Name)		Raoi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		30	10 33
Inspected By (Sign) & Date			Raoi 30/10/23	

Reviewed by (Engineer-CNC) *Saha* 30/10/23

Manager-QA