

6394



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.		10586	40/40
2	Machined By		V.T.L.H/A Shop	8195 Drg No. 10675
3	Pallet Die No.		10675(4.0) H/A	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/A / Step OD, 491 H/A	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H/A	
7	Width of Pellet Die	Drg. No.	158 H/A	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/A / 12x8x3 H/A	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/A Shop	Tapping No. of holes, 8 Both side
12	Tapping PCD		454 H/A	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.4 H/A	Tapping Depth = 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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							Ravi 30
2	External Relief Dia	4.5 H/A	Outside (2-2)		Inner				
3	External Relief Depth		4 H/A		Mill				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark For name
6	Material Sent For Hardening On Date		30	10	23				

Inspected By (Sign) & Date

Ravi 30/10/23

Reviewed by (Engineer-CNC)
Sethi 30/10/23

Manager-QA