

6415



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.		10603 ✓	55/60
2	Machined By		V.T.C. H/c Shop	Drg No. 18.0. 312
3	Pallet Die No.		10824 (3.5) H/H	Rev. 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	78.0 H/H, Step 00. 791.8 H/H	Step length 27
6	Inside Diameter	Drg. No.	66.0.12 H/H	Udenutz 8 H/H
7	Width of Pellet Die	Drg. No.	394 H/H	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 12 H/H 21.5 x 8 x 12 H/H	
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 12 Both Side
12	Tapping PCD		725 H/H	
13	Tapping Hole Diameter		H2 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 31.4 H/H Tapping Depth - 29.7 H/H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 10/11/23

1	As per programme no.			2 Slot 32.1 H/H wide 8 H/H Deep Both Side
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No - 2 Hole Closed (D)	

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

1	Counter Sinking Depth & Finish	OK							Row = 51
2	External Relief Dia	4.0 H/H	outside (3-3)		Inner				
3	External Relief Depth		12 H/H		5 H/H				
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date		10	11	23				
Inspected By (Sign) & Date			Ravi 10/11/23						

Reviewed by (Engineer-CNC)

Manager-QA