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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.		10603	55/60
2	Machined By		V.T.L. H/c Shop	Drg No. 13.0.312
3	Pallet Die No.		10825 (3.5) H/H	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	78.0 H/H Step 002 = 79.2 H/H	Step length, 27 H/H
6	Inside Diameter	Drg. No.	66.0 12 H/H	Under cut = 6 H/H
7	Width of Pellet Die	Drg. No.	32.4 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		72.5 H/H	
13	Tapping Hole Diameter		M2 = Check by M2 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	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 10/11/23	2 Slot 32.1 H/H width 8 H/H Deep Both Side
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		Row = 51
2	External Relief Dia	4.0 H/H	outside (3-3)	Innen
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 Purnoce	
6	Material Sent For Hardening On Date		10 11 23	
Inspected By (Sign) & Date			Ravi 10/11/23	

Sobit 10/11/23

Reviewed by (Engineer-CNC)

Manager-QA