

11147



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.		10702	39/55
2	Machined By		V.T.L. n/c Shop	Drg No. 1-8.0.457
3	Pallet Die No.		11147 (3.5) n/c	Rev 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770 n/c	Step OD 200 n/c
6	Inside Diameter	Drg. No.	860.12 n/c	Step length 20 n/c
7	Width of Pellet Die	Drg. No.	316 n/c	Under cut 15 n/c
8	Grooves as per Drawing	Drg. No.	20x8x7.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	20x8x7.5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		795 n/c	Tapping No of holes = 12 Both Side
13	Tapping Hole Diameter		M20 - Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 25.4 n/c	Tapping Depth 23.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/11/23

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 - 1 Hole Closed (A)

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0 n/c	Outside (3-3)		Inner				
3	External Relief Depth		23 n/c		16 n/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		21	11	23				

Inspected By (Sign) & Date

Ravi 21/11/23

SJS 21/11/23

Reviewed by (Engineer-CNC)

Manager-QA