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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.		10532	27/55
2	Machined By		N.T.L. N/C Shop	Drg No. 18.02 594
3	Pallet Die No.		11409 (4.5) MM	Rev=00
4	Die Category	Drg. No.	320	
5	Out Side Diameter	Drg. No.	530MM Step OD 2 49MM	Step length = 17.5
6	Inside Diameter	Drg. No.	480.2 MM	
7	Width of Pellet Die	Drg. No.	182.1 MM	
8	Grooves as per Drawing	Drg. No.	1078x3MM 1078x3MM	
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		454MM	
13	Tapping Hole Diameter		Ø34" = Check by Ø34" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.4 MM Tapping Depth = 16.8 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 20/11/23

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

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

1	Counter Sinking Depth & Finish	OK								Ravi 23
2	External Relief Dia	5.5 MM	outside (2.2)		inner					
3	External Relief Depth		32 MM		28 MM					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		20		11		23			

Inspected By (Sign) & Date

Ravi 20/11/23

Reviewed by (Engineer-CNC)

Manager-QA