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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.		10687	47/50
2	Machined By		V.T.L H/C Shop	Dy. No. 1.8.02 9980
3	Pallet Die No.		11078 (21.5) H/C	Rev 2.00
4	Die Category	Drg. No.	Ext. outside	
5	Out Side Diameter	Drg. No.	6.20 H/C Step 0.02 Tapper 21.2° Step length 18.5	
6	Inside Diameter	Drg. No.	5.20 H/C	
7	Width of Pellet Die	Drg. No.	2.22 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping dia of holes = 12 Botu side
12	Tapping PCD		56.5 H/C	
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 21.0 H/C Tapping Depth 19.0	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Rev 2.00
2	External Relief Dia	5.0 H/C	Outside (3-3)	Inner
3	External Relief Depth		7 H/C	3 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Pomace	
6	Material Sent For Hardening On Date		21	23
Inspected By (Sign) & Date			Ravi 21/11/23	

Reviewed by (Engineer-CNC)
Soh...
 21/11/23

Manager-QA