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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10039/	marking 265/70
2	Machined By		V.T.L. n/c Shop	26/71
3	Pallet Die No.		11165 (4.0) n/c	Reason
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1048 n/c Shop 1033 n/c	Tapping 3"
6	Inside Diameter	Drg. No.	900.12 n/c	Step length 37 n/c
7	Width of Pellet Die	Drg. No.	375 n/c	
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 n/c / 29.5 x 8 x 13 n/c	
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: 15 Both Side
12	Tapping PCD		970 n/c	
13	Tapping Hole Diameter		n/c 2 Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 38.9 n/c	Tapping Depth 36.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 9/12/23	2 Slot
1	As per programme no.			38.1 n/c width
2	Gun Drilling Work Completed On			7.5 n/c Depth
3	Hole Finish In Gun Drilling	Marked	OK	Both Side
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		Reason 53
2	External Relief Dia	4.5 n/c	outside (4-4)	Inner
3	External Relief Depth		13 n/c	5 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		9 12 23	
Inspected By (Sign) & Date			Ravi 9/12/23	

Reviewed by (Engineer-CNC)

Manager-QA