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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.		10673	40/55/80
2	Machined By		V.T.L M/c Shop	Qty No. 13.02859
3	Pallet Die No.		11478 (8.0) H4	Rev. 02
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	730 H4, Step 00, 732 H4	632 H4 Step length 18.5
6	Inside Diameter	Drg. No.	572.14 H4	
7	Width of Pellet Die	Drg. No.	219 H4	
8	Grooves as per Drawing	Drg. No.	67x8x8 H4 98x8x8 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No. of holes 6
12	Tapping PCD		650 H4	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and 2nd side One Slot	
15	Tapping Hole Depth		Drill Depth 40 H4 Tapping Depth 38.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/11/23

1	As per programme no.			1 slot
2	Gun Drilling Work Completed On			26 H4 width
3	Hole Finish In Gun Drilling	Marked	OK	19 H4 Depth
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 9
2	External Relief Dia	8.5 H4 9.0 H4	8.5 H4 All Lines	9.0 H4 All Lines				
3	External Relief Depth		40 H4	25 H4				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		23	11	23			
Inspected By (Sign) & Date		Ravi 23/11/23						

23/11/23

Reviewed by (Engineer-CNC)

Manager-QA